



## RASI E 11016-G

premium

BASIC COATED LOW HYDROGEN  
ELECTRODES

### TECHNICAL SPECIFICATION SHEET

#### CHARACTERISTICS

RASI E 11016 G is a Medium heavy coated hydrogen controlled all position electrode giving Low Alloy Steel Weld metal with 2.6% Cr, 2% Ni, 1.2% Mo, 0.15% V giving a Tensile Strength of 960 N/mm<sup>2</sup>. The welds are Radio graphically sound and the third layered weld deposit hardness is up to 300BHN

#### APPLICATIONS

RASI E 11016G is used for machinery parts made of High tensile strength steels, Earth moving equipments, forging dies, Automotive parts, chemical plants where Ni-Cr-Mo steels are used.

#### CLASSIFICATIONS

AWS-SFA 5.5 : E 11016 G  
IS : 1395 E 76 B GI 26

#### CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.09%	Silicon - 0.40%
Manganese - 1.70%	Sulfur - 0.03%
Phosphorus - 0.03%	Cr - 3%
Mo - 1.5%	Ni - 2.2%
	V - 0.20%

Note: Single Values shown above are maximum

#### MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm<sup>2</sup>) - 960 MIN.  
Yield Strength (N/mm<sup>2</sup>) - 880 MIN.  
Elongation % - 16%.MIN

#### WELDING CURRENT : DC± / AC 50 V

Ø 2.50 mm - 60 - 100 Amps  
Ø 3.15 mm - 100 - 140 Amps  
Ø 4.00 mm - 140 - 190 Amps  
Ø 5.00 mm - 190 - 240 Amps.  
Ø 6.30 mm - 240 - 300 Amps.

**\*FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- [info@rasielectrodes.com](mailto:info@rasielectrodes.com)**

storage - Store in warm and dry place. If damped re dry at 300°C for 1 hour.

\*All statements, information and data given are believed to be accurate and reliable but are presented without guarantee, warranty or responsibility of any kind, expressed or implied.

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