



BASIC COATED LOW HYDROGEN ELECTRODES

RASI E 7016 LH

premium

TECHNICAL SPECIFICATION SHEET

CHARACTERISTICS

Spontaneous and quiet arc
Extremely low spatter level
Excellent looking weld bead
Self Disposal of slag
Multi position capability.
Radiographic quality welds

APPLICATIONS

For the welding of mild steel, pressure vessel steels, ship plates, free cutting steels, buffer layer for crack resistant base in hardfacing and for joining cast iron to mild steel as strength weld. The welds satisfactory withstand static and dynamic loading.

CLASSIFICATIONS

IS. : 814 EB 5426 H3X
AWS : A5.1 E 7016

CHEMICAL COMPOSITION OF ALL WELD METAL

Carbon - 0.10% Silicon - 0.75%
Manganese - 1.60% Sulfur - 0.03%
Phosphorus - 0.03%

Note: Single Values shown above are maximum

MECHANICAL PROPERTIES OF ALL WELD METAL

Tensile Strength (N/mm²) - 510 - 610
Yield Strength (N/mm²) - 360 MIN.
Elongation % - 24% MIN.
CVN Impact at -30°C - 27 J 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**

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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