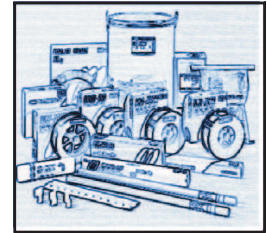


Shielded Metal Arc Welding

ANU BOND Miracle 7016

Low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel

Classification :
ASME / AWS A5.1 E7016
IS: EB5426H₂JX
EN499 E423B
JIS Z3212 D5016



Features : . Suitable for butt and fillet welding of heavy structures
Excellent mechanical properties

Redrying Conditions: 300~350°Cx0.5~1 h

Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.08	0.60	0.94	0.011	0.006
Guaranty	0.05~0.10	0.75	1.60	0.020	0.020

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (CXh)
Example	500	570	32	-29 C:120	AW
	420	520	33	-29 C:150	620×1
Guaranty	≥ 400	≥ 480	≥ 22	-29 C≥27	AW
	≥ 350	≥ 460	≥ 25	-29 C≥27	620±15x1

Recommended welding parameters

Dia.	2.50mm	3.15mm	4.0mm	5.0mm	6.0mm
F, HF, H, VD	55~85A	90~130A	130~180A	180~240A	210~310A
VU, OH	50~80A	80~120A	110~170A	150~200A	-

Polarity

Example AC
Guaranty AC, DC-EP

Approval

Packages

Dia. (mm)	Length (mm)	Pack per Carton (No. of Packs)	Qty per Carton (Kgs)
2.50	350	12	30 Kg
3.15	450	12	36 Kg
4.00	450	12	36 Kg
5.00	450	12	36 Kg

We Weld Relations...

