

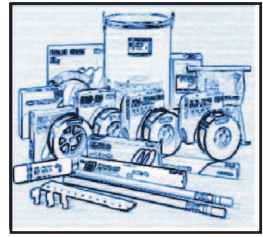
Shielded Metal Arc Welding

ANU BOND- 7016 (W) (E 7016)

AWS: SFA 5.1, E 7016,IS: 814 EB 5426 H3X

Application :

It is used for welding of high Carbon steel to Mild Steel, High Carbon Steel Parts, Low Alloy Steel, Armour Plates, Cast Steel as well as unknown composition of steel.



Characteristics on Usage :

It is medium coated, hydrogen controlled all position electrode. It give a smooth clean weld deposit with least spatter due to having a special type of lime coated. The weld metal is highly resistant to cracking and gives radiographic quality. Dry the electrodes at 300c for hour for best result.

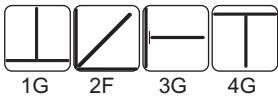
Chemical composition of All-Weld metal (%) as per AWS

C	Mn	Si	S	P	Cr	Ni	Mo	V
0.15 Max	1.60 Max	0.75 Max	0.035 Max	0.035 Max	0.20 Max	0.35 Max	0.30 Max	0.08 Max

Mechanical properties of all-weld metal as per AWS

UTS (N/mm ²)	Y. S. (N/mm ²)	Elongation (L=4d) %	Impact (CVN) AT +27 ⁰ C (J)	Hydrogen(Mercury method) in 100gm weld metal
520Min	400 Min	22 % Min	40 Joules Min	5 ml (Max)

Welding Positions



Packaging & Welding Current

SIZE (mm)	Kg Per Packet	Kg Per Carton	Current (Amps)	In Amps
2.50 x 350	2.50 Kg	12.5 Kg	AC / DC (+)	60-90
3.15 x 450	3 Kg	15 Kg		100-140
4.00 x 450	3 Kg	15 Kg		140-180
5.00 x 450	3 Kg	15 Kg		190-250

