



Selectarc B7016Sp

*Basic Electrode
Double coated*

Classification

AWS A5.1 : E7016

EN 499 : E 38 2 B 1 2 H10

ISO 2560-A : E 38 2 B 1 2 H10

Description & Applications

Basic coated electrode presenting exceptional welding characteristics due to its double coating. Arc very stable in all positions, almost spatter free, easy removal of the slag. Universal use for welding metal constructions and for repairing. Recommended for root passes and on badly prepared joints too.

Base materials

Construction steels for general use, Tube steels, Ship steels, Steels for Boiler and Pressure Vessels, High strength steels, Heat resisting steels, Cold tough steels

| | | |
|----------------|---|---|
| EN-Designation | S185 – S355 GP240R L210 – L360 | P235 – P355 P235GH – P265GH |
| Ship steels | Quality A, B, C and D | |
| ASTM | A285 grade C A442 grade 55 , 60 A516 grade 55 , 60 , 65 ,70 | A414 grade C, D, E, F A515 grade 55 , 60 , 65 , 70 |

Typical Weld Metal Composition (%)

| C | Si | Mn | P | S | Fe |
|-------|-----|-----|-------|-------|------|
| <0.10 | 0.7 | 0.9 | <0.02 | <0.02 | Rem. |

All Weld Metal Mechanical Properties

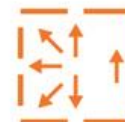
| R _e (MPa) | R _m (MPa) | A ₅ (%) | KV (J) | |
|------------------------|------------------------|----------------------|----------|-----|
| 450 | 550 | 27 | +20°C | 150 |
| | | | -20°C | 80 |
| | | | -50°C | 70 |

Welding Current & Instructions

| Electrode | ØxL (mm) | 2,5x350 | 3,2x350 | 3,2x450 | 4,0x450 | 5,0x450 |
|-----------|------------|---------|---------|---------|---------|---------|
| Current | (A) | 80 | 115 | 115 | 150 | 190 |

Redrying: 2h at 300°C, if necessary. Interpass temperature: < 250°C.

Ind.12



= + ~ 70V



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