

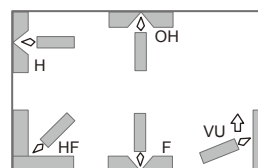
Low hydrogen type covered electrode

Classification: ASME / AWS A5.1 E7016
EN ISO 2560-A-E 42 3 B
JIS Z3211 E4916

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

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

Welding Positions



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 (°C×h)
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

	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
Dia.	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
F, HF, H	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

Approvals

ABS	LR	DNV	BV	NK	GL
3H10,3Y,3Y400	3Ym H15	3YH10	3H.3YHH	KMW53Y40H10	3YH15

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	350	5	20	20
3.2	350	5	20	31
4.0	400	5	20	54
5.0	450	5	20	97
6.0	450	5	20	137