

RATNA 7016W

Lime type Medium heavy coated, hydrogen controlled Electrode for high carbon and high sulphur steels.

CLASSIFICATION : AWS/SFA-5.1: E 7016 , BS 639 E 5144B24(H)
IS-814: EB 5426 H3X , DIN 1913 E 4344B1029

APPROVAL :

CHARACTERISTICS : A medium heavy coated, hydrogen controlled, basic coated electrode for welding unknown composition steels, difficult to weld steels with high carbon and high sulphur, cast steels. Weld metal is highly crack resistant and is of radiographic quality.

APPLICATION :

- 1) Suitable for welding unknown composition steels.
- 2) Low alloy steels.
- 3) Mild steel to high carbon steel.
- 4) Steel component with high carbon and high sulphur.
- 5) Cast iron repairs etc.
- 6) Armor plants.

RE-DRY CONDITION : Re-Dry the electrode at 250-300°C for one hour, for best results.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.10 max.	0.80-1.30	0.60 Max	0.030 Max	0.030 Max

ALL WELD MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
400-500	510-600	24-32	-30 ⁰ C : 50-80 J

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 90 V)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-100	200	800
3.15/ 3.20 X 450	1/ 8" X 18"	90-140	125	500
4.00 X 450	5/ 32" X 18"	130-180	80	320
5.00 X 450	3/ 16" X 18"	180-250	55	220

Customer packing on request.