

# RATNA 7016

## A Hydrogen controlled basic coated Electrode For welding high and medium tensile steels.

**CLASSIFICATION** : AWS/SFA-5.1: E 7016 , BS 639 EB5144B24(H)  
IS-814: EB 5426H3X , DIN 1913 5144B1026

**APPROVAL** :

**CHARACTERISTICS** : A hydrogen controlled basic coated electrode for welding medium and high tensile structures, grey cast iron components, low and medium carbon steels. The deposits are of radiographic quality coupled with excellent mechanical properties.

**APPLICATION** :

- 1) Suitable for overlaying buffer layer before hardfacing.
- 2) Joining mild steel to carbon steel.
- 3) Repairing cast iron component provided non machinable welds are permitted.
- 4) Joining steel girders to rail.
- 5) Earthmoving machineries.
- 6) Boilers, offers drilling rigs and flat forms.
- 7) Pressures vassals Tanks.
- 8) Blast Furnace Sells.

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

### ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P
0.10 max.	0.80-1.50	0.75 Max	0.030 Max	0.030 Max

### ALL WELD MECHANICAL PROPERTIES:

YS (N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT
420-510	510-610	22-32	-30 <sup>0</sup> C : 50-100 J

### DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC+/AC 70V)	No. of Pcs./pkt.	No. of Pcs./Case
2.50/ 2.40 X 350	3/ 32" X 14"	70-100	195	780
3.15/ 3.20 X 450	1/ 8" X 18"	90-130	120	480
4.00 X 450	5/ 32" X 18"	140-180	80	320
5.00 X 450	3/ 16" X 18"	190-230	50	200

Customer packing on request.