



# CEWELD E 7016

**TYPE** E 7016 Double coated semi basic welding electrode for stick welding.(Type E7016, E 42 4 B)

**APPLICATIONS** CEWELD® E 7016 is a Double-coated semi basic CTOD tested electrode with excellent welding properties in difficult positions and shows high mechanical properties. It is particularly suited for cheap welding machines with low open voltage on AC and DC+.  
Repair welding, root runs, vessel, shipbuilding, construction buildings, fences, bridges

**PROPERTIES** Excellently suited for old and rusty material because of its stable and intensive arc. Well suited for root runs and in the maintenance and repair sector due to its absolute insensitiveness for rust or diluted base metals. Hydrogen content: HD < 10ml/100g weld metal.

**CLASSIFICATION**

AWS	A 5.1: E 7016
EN ISO	2560-A: E 42 4 B 12 H10
F-nr	4
FM	1

**SUITABLE FOR** **Rp < 420 MPa (60ksi) ISO 15608: 1.1 ReH < 275 MPa, 1.2 275 < ReH < 360 MPa , (1.3 ReH > 360 MPa < 420 MPa)**  
 1.0345, 1.0345, 1.0348, 1.0352, 1.0418, 1.0420, 1.0425, 1.0425, 1.0425, 1.0451, 1.0452, 1.0453, 1.0457, 1.0459, 1.0460, 1.0460, 1.0461, 1.0486, 1.0490, 1.0491, 1.0619, 1.1100, 1.0409, 1.0421, 1.0426, 1.0429, 1.0430, 1.0436, 1.0473, 1.0481, 1.0482, 1.0484, 1.0505, 1.0545, 1.0546, 1.0562, 1.0566, 1.0570, 1.0578, 1.0581, 1.0582, 1.8902, 1.8912, 1.8932  
 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,  
 S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240,  
 A, B, D, E, A 32-E 36  
 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, Domex 315-420MC, MC Plus, ML

**APPROVALS** CE TÜV (12531.00)

**WELDING POSITIONS**

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	P	S
	0.05	0.65	1	0.025	0.025

ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	
					-40°C	-30°C
	As Welded /	450	560	25	75	100

**REDRYING TEMPERATURE** 400°C / 1 hr

**GAS ACCORDING EN 14175**



# CEWELD E 7016

E 7016 4,0 X 350MM

Type	KG/unit	EANCode
Can	2,4	8720663400987

E 7016 2,5 X 350MM

Type	KG/unit	EANCode
Vacuum	1,9	8720682050255

E 7016 3,2 X 350MM

Type	KG/unit	EANCode
Vacuum	1,9	8720682050293

E 7016 3,2 X 450MM

Type	KG/unit	EANCode
Vacuum	2,5	8720682050309

E 7016 4,0 X 450MM

Type	KG/unit	EANCode
Vacuum	2,3	8720682050316

E 7016 5,0 X 450MM

Type	KG/unit	EANCode
Vacuum	2,5	8720682050323