

FILARC 56S

Type Basic

SMAW
E7016-1

Description

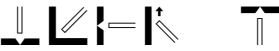
Basic, thin-coated AC/DC electrode providing excellent mechanical properties. The electrode ensures fully penetrated root passes, even under adverse conditions. Low moisture content coating and high resistance to moisture re-absorption.
The electrode is CTOD tested.

Recovery

100%

Welding current

DC+(-), AC OCV 70 V



Classifications

SFA/AWS A5.1	E7016-1
EN 499	E 42 5 B 12 H5

Typical all weld metal composition, %

C	Si	Mn
0.06	0.4	1.3

Typical mech. properties all weld metal

Yield stress, MPa	>420
Tensile strength, MPa	<640
Elongation, %	>22

Charpy V

Test temps, °C	Impact values, J
-20	>150
-40	>80
-50	>47

Approvals

ABS	3H5, 3Y
BV	3YHH
CL	EN 499
DB	10.105.15
DNV	4YH5
DS	EN 499
GL	4YH10
LR	4Y40H10
MOD	B + BX
RS	4Y42HH
SFS	EN 499
SS	EN 499
UDT	DIN 1913
U	10.105/1
VdTÜV	03012

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.0	300	35-60	22	-	-	-	43
2.5	350	55-85	22	0.58	90.0	0.8	50
3.2	350	80-140	22	0.61	52.0	1.3	53
3.2	450	80-130	22	0.61	41.0	1.2	73
4.0	350	110-180	22	0.64	34.0	1.7	62
4.0	450	110-170	22	0.65	26.0	1.7	83
5.0	450	180-230	22	0.66	17.0	2.4	90