



BASIC 55 WELDING ELECTRODES Ø 4,0 X 450MM - E7016 - E 38 3 B 12 H10



Standards

- AWS A5.1: E 7016
- EN ISO 2560-A: E 38 3 B 12 H10

Type of coating

- Basic-rutile

Current type

- AC/DC

Welding positions

- All positions, except vertical downward

Basic materials to be welded

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel: S185 - S355J2G3, St.33 - St.52.3, C(K)10 - C(K)35
- Boiler steel: P235GH - P355GH, HI, HII, 17Mn4, 19Mn6
- Fine grain steel: P275N - P355NL2, S275N - S420N, StE285 - EStE355, StE285TM - EStE355TM
- Pipe steel: P235T1 - P355N, L210 - L415MB, St37.0 - St52.4, St45.8, X42 - X60, StE210.7 - StE360.7TM
- Cast steel: GP240R, GS45

Applications

- Shipbuilding and offshore
- General manufacturing and construction
- Power generation
- Repair and maintenance

Chemical composition

- Carbon (C): 0.06%
- Manganese (Mn): 0.90%
- Silicon (Si): 0.70%
- Sulfur (S): ≤ 0.025%
- Phosphorus (P): ≤ 0.025%

Mechanical properties

- Condition: as welded
- 0.2% Yield strength: ≥ 400 MPa
- Tensile strength: ≥ 490 MPa
- Elongation Lo = 5d: ≥ 22%
- Impact values:
 - -20 °C: > 90 J



HI 1354540 - W19044	
Welding current max.	190 A
Elongation min.	22 %
Tensile strength min.	490 N/mm ²
Yield strength min.	400 N/mm ²
MMA	
ImpactValue	20°C ≥ 90 J
Diameter	4 mm
Length	450 mm
Weight	5,2 kg
AWS standard	AWS A5.1: E7016
EN standard	EN ISO 2560-A: E 38 3 B 12 H10
Welding positions	All positions, except vertical downwards
Coating type	Basic-rutile