

LINCOLN 7016 DR

SMAW

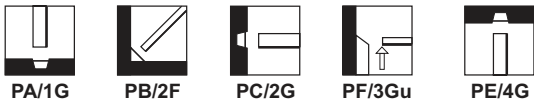
CLASSIFICATION

AWS A5.1	E7016	A-Nr	1
ISO 2560-A	E 42 2 B 1 2 H10	F-Nr	4
		9606 FM	1

GENERAL DESCRIPTION

Double Coated Basic Electrode
 Stable arc and smooth welds
 Ideal for pipe welding in both root pass and filling
 Excellent gap bridging
 Good X-ray soundness and start/restart behaviour

WELDING POSITIONS (ISO/ASME)



CURRENT TYPE

AC/DC +

APPROVALS

TÜV

Pending

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	HDM
0.08	1.2	0.6	5 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
					-20°C	-30°C
Required: AWS A5.1		min. 400	min. 490	min. 22		27
ISO 2560-A		min. 420	500-640	min. 20	47	
Typical values	AW	455	560	28	70	45

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	3.2	4.0
	Length (mm)	350	350	450	450
Carton + PE foil	Pieces / unit	205	137	134	81
	Net weight/unit (kg)	4.1	4.3	5.5	5.2

Identification Imprint: Tip Color: none

LINCOLN 7016 DR: rev. C-EN01-01/02/16

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.
 Fumes: Safety Data Sheets (SDS) are available on our website.

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EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to EH36
Cast steels	
EN 10213-2	GP240R
Pipe material	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415, L445
API 5LX	X42, X46, X52, X60
EN 10216-1	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3/4	S275, S355, S420

CALCULATION DATA

Sizes		Current range (A)	Current type	Arc time - per electrode at max. current - (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
Diam. x length (mm)									
2.5x350		60-90							
3.2x350		95-150							
3.2x450		95-150							
4.0x350		140-190							

*Stub end 35mm

REMARKS / APPLICATION ADVICE

Redry electrodes 2-4h 350 ±25°C after removal from cardboard boxes