

EASYARC™ ID7016P



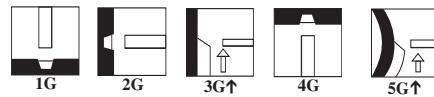
General Applications

- Basic low hydrogen electrode (HDM 5mL/100g, per AWS A4.3).
- Excellent root pass electrode, particularly when low hydrogen is demanded and open gap conditions exist, as in pipewelding (dia. 2.5 & 3.2mm).
- Impacts exceed AWS A5.1 requirements when tested at -40°C.
- For all positions except vertical down. Particularly suitable for vertical up welding.

Approvals

ABS: 3YH5
 Lloyds: BF 3m, 3Ym H5
 BKI: 3YH5

Welding Positions



Polarity

DC+, DC-, AC

Classification

AWS A5.1 :E7016P

CHEMICAL COMPOSITION (W%), TYPICAL ALL WELD METAL

%C	%Mn	%Si	%P	%S
0.07	1.10	0.30	0.01	0.01

MECHANICAL PROPERTIES

Condition	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation (%)	Impact ISO-V(j) -30°C
Required	400	490	22	27
Test Results	450	550	28	135

RECOMMENDED CURRENT RANGE (AMPS)

Electrode Size (mm)	AC	DC+,DC-
2.5	70 - 80	60 - 70
3.2	90 - 130	80 - 120
4.0	130 - 160	120 - 150

PACKAGING AND AVAILABLE DIAMETERS

	Diameter (mm)	Length (mm)	Weight Set (kg)		
			Inner Box	Master	Pallet
Easyarc™ ID7016P	2.5	350	5	20	1900
	3.2	350	5	20	1900
	4.0	350	5	20	1900

WELDING TECHNIQUES

DC positive polarity has a strong arc with moderate spatter level. The penetration is greater than that of DC negative. For vertical up welding, a side-to-side weaving motion with a relatively steep welding angle produces a flat to slightly concave bead with the 2.5 and 3.2mm sizes. Excellent tie-in to sidewalls and no undercutting is also a feature of Easyarc™ ID7016P on DC positive polarity. DC negative polarity has the advantage of low spatter levels and a flat, smooth bead on horizontal fillets. The penetration on this polarity is more shallow than with DC positive. DC negative polarity is recommended for open gap root pass welding for vertical up applications.

AC operation is closer to DC positive with regard to spatter, penetration and bead appearance. Arc stability on AC is very good. Easyarc™ ID7016P can be used where open circuit voltage is as low as 60V.

For all applications, a tight arc should be held to maintain weld soundness and mechanical properties. All sizes can be used in out-of-position welding (excluding vertical down). The 4.0mm diameter Easyarc™ ID7016P will produce a slightly more convex bead shape in the vertical up position. For best quality welds, any water, oil, grease, loose scale and dirt should be removed from the plate or pipe prior to welding.

Easyarc™ ID7016P does not have an 'MR' type coating. Proper storage and redrying procedures should be followed to prevent the consequences of moisture pick up. On horizontal welds, a maximum 1.5mm arc length or drag technique should be used with all diameters. This will ensure better impact properties and higher quality x-rays.

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