MILD STEEL STICK ELECTRODE

# EASYARC™ 7016


EASYARC™ 7016 is a low-hydrogen type electrode for all-position welding of mild and low alloy steels. The easily controlled arc of EASYARC™ 7016 makes it easy to use on either AC or DC polarity. EASYARC™ 7016 offers excellent mechanical properties and crack resistance. It is also easy to strike and restrike.

## APPROVALS

CCS: 3YH10

ABS: 3YH10

LR: 3m 3Ym H15

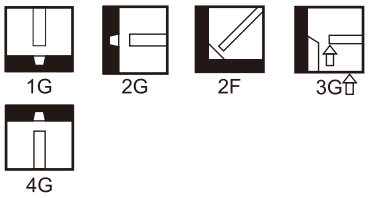
## CONFORMANCE

AWS/ASME A5.1/SFA5.1 E7016

## ADVANTAGE LINCOLN

- All-position stick electrode
- Soft, stable, low spatter arc
- Smooth bead appearance
- Easy slag removal
- Excellent crack resistance and X-ray performance
- Manufactured under a quality system certified to ISO 9001 requirements.
- Available in PERMAPACK™ (1) (Vacuum Sealed)

## WELDING POSITIONS




## APPLICATION

EASYARC™ 7016 is a multi-purpose electrode with excellent operator appeal. EASYARC™ 7016 can be used for general construction welding applications such as bridges, buildings, ship building and pressure vessels. EASYARC™ 7016 can also be used for the construction or repair of earth moving or farm equipment. EASYARC™ 7016 is excellent for the welding of medium carbon steel, low alloy, and thick plate such as (ASTM A131) Grade A, B, D and E ship plates.

## GUIDELINES FOR USE

- All water, rust and oil should be completely removed from base material to prevent cracking and blowholes.
- For improved impact properties, avoid use of excessive amperage levels.
- Backstep method should be applied to prevent blowholes and pits during arc start.
- Arc length should be kept as short as possible during welding.
- If weaving is required, the width should not exceed 3x the diameter of the electrode.

## REDRYING

All controlled hydrogen electrodes will perform optimally when they are dry. Unopened Lincoln PERMAPACK's provide excellent protection against moisture pick-up in good storage conditions. Should re-drying be necessary, remove electrodes from the packet / container and spread thinly and evenly on racks in a ventilated oven. For electrodes that have had a short or mild exposure to the atmosphere then re-drying at 572°F(300°C) for 1 hour will be sufficient. For electrodes that have been exposed to longer or more aggressive conditions or for critical work re-drying at 572-662°F (300-350°C) for 1-2 hours is recommended. After re-drying electrodes should be stored in a hot box.

## DIAMETERS / PACKAGING

| | Diameter × Length (mm) | Weight (kg) | | Packet per Carton | Product No. |
|---|---|---|---|---|---|
| | | Packet | Carton | | |
| Box | 2.5 × 300 | 5 | 20 | 4 | CC010351 |
| | 3.2 × 350 | 5 | 20 | 4 | CC010352 |
| | 4.0 × 400 | 5 | 20 | 4 | CC010353 |
| | 5.0 × 400 | 5 | 20 | 4 | CC010354 |
| PERMAPACK™ (1) Tube | 2.5 × 300 | 2.5 | 20 | 8 | CC010355 |
| | 3.2 × 350 | 2.5 | 20 | 8 | CC010356 |
| | 4.0 × 400 | 2.5 | 20 | 8 | CC010357 |
| | 5.0 × 400 | 2.5 | 20 | 8 | CC010358 |

(1) The electrodes are placed in a plastic tube, and then are vacuum-packed in moisture proof, foil-poly bags to prevent moisture pick-up.

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## MECHANICAL PROPERTIES, ALL WELD METAL

| | Yield Strength Mpa | Tensile Strength Mpa | Elongation (%) | Impact ISO -V, (J) -30°C |
|---|---|---|---|---|
| **Requirements AWS A5.1: E7016** | min.400 | min.490 | min.22 | min.27 |
| **Typical Values** | 470 | 560 | 24.5 | 108 |

Charpy V-notch impact tests can exhibit considerable variability depending upon the base plate, welding procedure, V-Notch location within the weld, and many other factors. Please contact your Lincoln sales representative for results or recommendations if your application has special requirements or considerations.

## CHEMICAL COMPOSITION, ALL WELD METAL

| | C | Mn | Si | S | P |
|---|---|---|---|---|---|
| **Requirements** AWS A5.1: E7016(%) **Max.** | **0.15** | **1.60** | **0.75** | **0.035** | **0.035** |
| **Typical Values(%)** | **<0.08** | **1.00-1.20** | **0.30-0.45** | **<0.020** | **<0.025** |

## RECOMMENDED WELDING CURRENT(AC, DC+)

| Diameter x Length (mm) | | 2.5 x 300 | 3.2 x 350 | 4.0 x 400 | 5.0 x 400 |
|---|---|---|---|---|---|
| Current (A) | AC | 55-85 | 90-140 | 140-180 | 180-240 |
| | DC+ | 50-80 | 80-120 | 130-160 | 160-200 |

**Customer Assistance Policy**

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

Subject to change - This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com.cn for any updated information.

LINCOLN® ELECTRIC

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