

Classification : AWS A5.1 : E7016

EN 499 : E 38 2 B 12H10

ISO 2560-A : E 38 2 B 12 H10

### Properties and applications:

Basic electrode with exceptional welding pleasure thanks to its double coating. Very stable arc in all positions, few projections, easy removal milk, universal use for all metal constructions, repairs, also recommended in the process of penetration and on unprepared joints.

### Weldable steel materials :

General-purpose construction steels, naval sheets, boiler steels and Pressure, High-Limit Steels elastic, Hot-resistant steels, cold-resistant steels		
EN-Designation	S185 - S355	P235 - P355
	GP240R	P235GH - P265GH
	L210 - L360	
Maritime sheets	Quality A, B, C, et D	
ASTM	A285 grade C	A414 grade C, D, E, F
	A442 grade 55,60	A515 grade 55,60,65,70
	A516 grade 55,60,65,70	

### Analyse of the type of deposited steel (%):

C	Si	Mn	P	S
<0.10	0.7	0.9	<0.02	<0.02

### Mechanical characteristics of the deposited steel

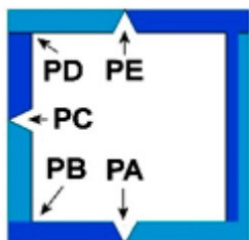
Re (MPa)	Rm (MPa)	A <sub>5</sub> (%)	KV (J)
450	550	27	+20° C > 150 -20° C > 80 -50° C > 70

### Average intensity & Conditions of use :

Electrode	øxL (mm)	2,5x350	3,2x350	3,2x450	4,0x450	5,0x450
Intensity	(A)	80	115	115	150	190

Heating process: 2 h at 300°C if necessary

### Welding position



**Responsibility:** The purpose of this document is to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for the applications for which it is intended. We reserve the right to modify the characteristics of its products without notice. Descriptions, illustrations and features are provided as an indication and cannot be the responsibility of our company. Smoke: View information on the Security Data Sheet available on request