

TECHNICAL DATA SHEET

BRAND NAME: MANGALAM E 7016

Classification:

AWS A /SFA 5.1 E 7016

IS 814:2004 EB5426H3X

DESCRIPTION AND APPLICATIONS:

Basic Coated low hydrogen iron electrode giving radiographic quality for joining high thickness joints subjected to restraint. Suitable for pipe welding application. Metal recovery around 100 %.

Typical applications:

- Heavy structures
- For joining mild steel to cast iron
- Shipbuilding
- Coaches & wagons
- Earth moving equipment

CHEMICAL COMPOSITION OF WELD METAL (%):

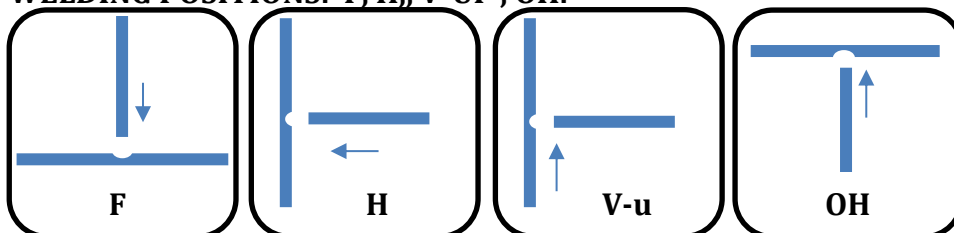
Elements	C	Mn	Si	S	P	Ni	Cr	Mo	V
%	0.12 Max	0.80- 1.60	0.75 Max	0.035 Max	0.035 Max	0.30 Max	0.20 Max	0.30 Max	0.08 Max

MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (N/mm ²)	YS (N/mm ²)	Elongation %	CVN Impact at Minus 30 °C (J)
510 -610	360 Min	20 Min	27 Min

Bend Test 3 T 180°	Satisfactory
Radiography Test II Blue Standard	Satisfactory
Storage Stability	Satisfactory

WELDING POSITIONS: F, H, V-UP, OH.



CURRENT CONDITION: AC/ DC (+)

PACKING DATA:

Size SWG	SIZE mm	No of electrodes /Packet	No of electrodes /Cartoon	Current in Amps
12	2.50 X 350/450	150	600	60-90
10	3.15 X 350/450	130	520	100-140
8	4.00 X 350/450	85	340	140-180
6	5.00 X 450	45	180	190 - 250