


Characteristics and Applications:

KE7016 is a low hydrogen type stick electrode for the welding of 490N/mm² high tensile steel, and it is good for all-position welding. The welding features are (1). the Arc is stable (2). less spatter (3). the slag covering is good (4). radiographic test result is good. It is specialized in backing welding.

Welding Position: 

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.15	1.60	0.75	0.20	0.30	0.30	0.035	0.035	0.08
KE7016	0.06	0.65	0.25	0.012	0.01	0.005	0.007	0.007	0.003

Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EL%	L.V.(J/°C)
AWS	400	490	22	27 / -30
KE7016	445	540	34	50 / -30

Notes on Usage:

1. Dry the stick electrodes at 350°C for one hour before welding.
2. Be sure to remove moisture, oil and rust on the base metal.
3. To avoid blowholes when striking the arc, please use back step method during welding process.
4. Keep short arc length when welding.
5. Current type: DC+ or AC. Using AC is recommended.

Sizes Available and Recommended Parameters:

Diameter(mm)	2.6×350	3.2×350	4.0×400	5.0×400
Current F	55-85	90-130	130-180	180-240
(Amp) OH,V	50-80	90-120	130-160	—