

## Characteristics and Applications:

KE7016-A1 is a low hydrogen type stick electrode whose chemical composition contains 0.5% Mo in the weld metal so as to secure the higher strength and good corrosion resistance. It is suitable for the welding of boiler and heat exchangers, such as plates of ASYM A204 and A335-P1 of pipes.

Welding Position:

## Typical Chemical Composition of All-Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Mo	P	S
AWS	0.12	0.90	0.60	--	0.40-0.65	0.03	0.03
Tested	0.07	0.68	0.48	0.15	0.53	0.015	0.011

## Mechanical Properties of All-Weld Metal:

Mechanical properties	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impace Value (J/°C)
AWS	390	490	25	---
Tested	510	582	29	174/R.T

## Notes on Usage:

1. Dry the stick electrodes at 350-400°C for one hour before welding.
2. Preheating and interpass temperature at 90 - 110°C and try to keep low hydrogen situation during whole welding process.
3. Keep short arc length when welding.
4. To relieve stress. PWHT at 605 - 635°C.
5. Polarity : DC or AC.

## Sizes Available and Recommended Parameter:

Diameter (mm)		3.2 x 350	4.0 x 400	5.0 x 400
Current (Amp)	F	90 - 130	140 - 190	190 - 240
	OH, V	80 - 120	120 - 160	-