



MODI - 7016

LOW HYDROGEN ELECTRODE

CLASSIFICATION : IS : 814-2004 : EB 5424 H₃X
AWS/A 5.1 : E 7016

APPROVALS : BIS, NTPC, EIL, TCE

CHARACTERISTICS : A basic coated low hydrogen electrode specially designed for welding of medium and high tensile ship steels of grade A, D & E. Radiographic quality welds, excellent ductility and notch toughness down to minus 30°C are some of the special characteristics of MODI-7016. Typical hydrogen content 4 ml/100gms of weld deposit.

APPLICATIONS :

- * Welding of HT52W and other high tensile grade steels,
- * Cast steels Used as buffer layer before hard surfacing.
- * Joining of M.S. with C.I.

RECOMMENDATIONS : To obtain the best results, re-dry electrode at 350°C for one hour. Keep the re-dried electrodes in an oven having temperature 70°C-100°C and use directly from the oven.

CHEMICAL ANALYSIS OF WELD-METAL(%) :	C	Mn	Si	S	P
	0.10max	0.9-1.3	0.6 max	0.03max	0.03max

MECHANICAL PROPERTIES OF ALL WELD-METAL (AS PER IS:814-2004) :	Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d) (%)	Reduction in Area (%)	CVN Impact Values at 27°C/-30°C
	Kg/mm ²	Kg/mm ²			Joules
	46-51	55-66	26 min	60 min	90/30
	N/mm ²	N/mm ²			Kgf.m.
	450-510	540-650			9/3

CURRENT CONDITIONS : USE DC (±) OR AC (70V)

Size (mm)	2.5x350	3.15x450	4.0x450	5.0x450	6.3x450
Amps	70-100	100-140	140-180	180-240	240-300



MODI ARC ELECTRODES CO.
Modinagar - 201 204 (U.P.)
Fax : 01232 - 242147
Phone : (01232) 325700, 325925, 243912
E-mail : modiarc@ndb.vsnl.net.in
Web Site : www.modielectrodes.com