



MODI - 7016S

LOW HYDROGEN ELECTRODE

CLASSIFICATION :

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

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-7016S. Typical hydrogen content is 3 ml/100gms of weld deposit.

APPLICATIONS :

- * Welding of HT 55 W and other high tensile grade steels.
- * Buffer layer before hard surfacing.

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	0.6-1.00	0.6 max	0.03max	0.03max

**MECHANICAL PROP-
ERTIES 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 46-51	Kg/mm ² 52-66			Joules 90/40
N/mm ² 450-500	N/mm ² 510-650	27 min	65 min	Kgf.m. 9/4

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

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