



# MODI XL 7016

## LOW HYDROGEN ELECTRODE

**CLASSIFICATION** : IS : 814-2004 : EB5424 H3X  
AWS/A 5.1 : E 7016

**APPROVALS** : BIS, CIB (Pb.)

**CHARACTERISTICS** : A basis coated low hydrogen electrode specially designed for welding of medium high tensile ship steels of grade A, D & E. Radiography quality welds, excellent ductility and notch toughness down to -30°C are some of the special features of MODI XL-16. Hydrogen content is 5ml/100gm max.

**APPLICATIONS** :

- Welding of HT52W and High Tensile Grade Steels
- Cast Steels
- Used as Buffer Layer before Hard Surfacing
- Joining of M.S. with Cast Iron

**RECOMMENDATIONS** : To obtain the best results, re-dry the electrodes at 350°C for one hour or at 250°C for two hours, keep the re-dried electrodes in an oven having 50°-60°C temperature and then use.

**CHEMICAL ANALYSIS OF WELD METAL (%)** :

	C	Mn	Si	S	P
	0.10 max	0.9-1.5	0.6 max	0.035 max	0.035 max

**MECHANICAL PROPERTIES OF 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 <sup>2</sup>	Kg/mm <sup>2</sup>	(%)	(%)	Joules
	46-51	55-66	26 min	60 min	90/30
	N/mm <sup>2</sup>	N/mm <sup>2</sup>			Kgf.m (min.)
	450-510	540-650			9/3

**CURRENT CONDITIONS : USE AC(70V) OR DC (+)**

Size (mm)	2.5 x 350	3.15 x 450	4.0 x 450	5.0 x 450	6.3 x 450
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Range (Amps.)	80-110	100-130	140-180	180-240	240-300
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## WELD EXCEL INDIA LTD.

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