

# NST E 7016

AWS: A5.1 E 7016

EN ISO 2560-A: E 42 4 B 12 H10



## All round rutile-basic electrode for welding unalloyed steels.

### General description:

NST E 7016, is a double coated, basic CTOD-tested electrode with excellent welding properties suitable for welding in difficult positions, with the exception of vertical down (PG).

It has a stable welding arc even at low current settings. Ignites and re-ignites easily.

Very suitable for welding root-runs with DC and AC currents.

This product is also available in a premium vacuum-packed version, with smart 2-in-1 packaging.

VacuumPack SuperDry 2-in-1

### Welding positions:



### Welding current:

DC+/AC

### Redrying:

380 °C/1 hour

### Typical chemical composition of all-weld-metal:

C	Si	Mn	P	S					
0,05	0,65	1,00	<0,035	<0,035					

### Diffusible hydrogen content (ml/100g):

### Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) -40 °C	
≥420	500-640	≥22	≥47	

### Guidance - Ampere (DC+/AC):

Electrode diameter	2,5 mm	3,2 mm	4,0 mm
Ampere / Volt	60-90	90-140	140-190

### Packaging information:

2,0 x 300 1,8kg pack, carton 10,8kg  
2,5 x 350 2,0kg pack, carton 12,0kg  
3,2 x 450 2,4kg pack, carton 14,4kg  
4,0 x 450 2,6kg pack, carton 15,6kg  
Vacuum pack: 2,5 x 350 1,8kg(2 x 0,9kg) pack, carton 16,2kg  
Vacuum pack: 3,2 x 350 1,6kg(2 x 0,8kg) pack, carton 16,0kg  
Vacuum pack: 3,2 x 450 2,0kg(2 x 1,0kg) pack, carton 20,0kg  
Vacuum pack: 4,0 x 350 1,0kg(2 x 0,5kg) pack, carton 10,0kg  
Vacuum pack: 4,0 x 450 1,2kg(2 x 0,6kg) pack, carton 12,0kg

### Approvals:

DNVGL, TÜV, CE

### Reference / date:

NST E 7016,  
English, 11.09.2018.

Perfect Welding

www.nst.no