



Low Hydrogen Electrodes for Mild & Medium Tensile Steel ALPHA 7016

Characteristics:

ALPHA-7016 is a heavy coated, all position, low hydrogen type electrode for the welding of medium high tensile structural steels, joining and surfacing of high strength steels such as Carbon Steel up to 0.4% C, Manganese Steel up to 2.0% Mn and Chromium Steel up to 0.4% C and 0.6% Cr. ALPHA 7016 is highly recommended for use on structures subject to impact and dynamic loading under severe service conditions.

Applications:

Building structures, Rail coaches and wagons, steels of unknown composition, Welding of cast iron, and Welding buffer layer before hard facing, Earth moving machinery etc.

Typical Weld metal Composition

Element	Percent
C	0.075
Si	0.50
Mn	1.10
S	0.017
P	0.022

Typical Mechanical Properties of all weld Metal

Ultimate Tensile Strength N/mm ²	Yield Strength N/mm ²	Elongation % (L=5d)	CVN Impact Values at -20°C. J
570	490	24	80 J

Classifications:

AWS/ A5.1:	E 7016
IS: 814	EB 5426 H 2 X
DIN 1913:	E 51 44 B 1026
BS 639:	E 42 3 B 31 (H)

Current Range & Packing Data :

Size MM DxL	Current Range (Amps) AC(70V) or DC (+)	Pieces per Packet	Pieces per Case
5.00x450	190-240	50	200
4.00x450	140-190	75	300
3.15x450	100-140	120	480
2.50x350	70-90	235	940

Welding Instructions:- Re-Dry the electrode at t 250 C to 300 OC for 02 hrs.

Contact us:-ALPHA ARC PVT. LTD.

H.O:- B-21, DSIIDC Complex, Kirti Nagar, New Delhi- 15
Works: B -5, Sec- A-5/6, Tronica City, Loni, Ghaziabad (U.P.) 201102
Phone No.011-41041441,Email-alphaarcpvtltd@gmail.com
Website: www.alphaarcelectrodes.com

