

SUPERCITO 7016S

MMA Electrodes C-Mn and low-alloy steels

Supercito 7016S is a basic coated low hydrogen electrode with a very thin coating to improve joint access making the electrode suitable for root pass welding. The principal applications are related to all positional welding of materials to BS 4360-50D or equivalent. The electrode is ideally suited for pipe welding using the vertical-up technique. The main related industries are offshore, petrochemical and power engineering. Efficiency 100%.

Classification

AWS	A5.1: E7016-1 H4
EN	499: E 42 5 B 12 H5
EN ISO	2560-A: E 42 5 B 12 H5

Approvals

Grades

ABS
BV
DNV
FI
LRS
M.O.D

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.06	1.10	0.60	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -50°C	Hardness
PWHT 620°C x 1h	≥ 390	500-620	≥ 22	≥ 110	-
As Welded	≥ 420	500-640	≥ 22	≥ 110	-

Materials

S(P)235-S(P)420, GP240-GP280

Storage and redrying

Keep dry and avoid condensation.

HD ≤ 5: Re-dry at 340-360 °C for 2 hours, 5 times max

HD ≤ 10: Re-dry at 300-350 °C for 5 hours, 5 times max

Current condition and welding position

DC+; DC-; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,0	300	35-60	11,8	5,9
2,5	350	60-90	19,0	11,0
3,2	350	90-130	31,1	19,0
3,2	450	90-130	40,6	25,0
4,0	350	140-170	45,5	27,0
4,0	450	140-170	59,6	36,2
5,0	450	170-210	91,0	59,0