

# LINCOLN 7016 DR

## CLASSIFICATION

<b>AWS A5.1</b>	E7016-H8	<b>A-Nr</b>	1
<b>ISO 2560-A</b>	E 38 3 B 1 2 H10	<b>F-Nr</b>	4
		<b>9606 FM</b>	1

## GENERAL DESCRIPTION

Double Coated Basic Electrode  
 Stable arc and smooth welds  
 Ideal for pipe welding in both root pass and filling  
 Excellent gap bridging  
 Good X-ray soundness and start/restart behaviour

## WELDING POSITIONS (ISO/ASME)



## CURRENT TYPE

AC/DC +

## APPROVALS

<b>DNV/GL</b>	<b>BV</b>	<b>LRS</b>
+	+	+

## CHEMICAL COMPOSITION (W%), ALL WELD METAL

<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>HDM</b>
0.08	1.2	0.6	5 ml/100 g

## MECHANICAL PROPERTIES, ALL WELD METAL

	Condition	Yield strength [N/mm <sup>2</sup> ]	Tensile strength [N/mm <sup>2</sup> ]	Elongation [%]	Impact ISO-V(J)	
					-20°C	-30°C
Required: AWS A5.1	AW	380	470-600	26	≥ 150	≥ 60

## PACKAGING AND AVAILABLE SIZES

	<b>Diameter (mm)</b>	2.5	3.2	3.2	4.0
	<b>Length (mm)</b>	350	350	450	450
<b>Carton + PE foil</b>	<b>Pieces / unit</b>	200	125	125	80
	<b>Net weight/unit (kg)</b>	3.9	4.1	5.3	5.2

Identification Imprint: Tip Color: none

LINCOLN 7016 DR: rev. C-EN05-16/12/20

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## EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
<b>General structural steels</b>	
EN 10025	S185, S235, S275, S355
<b>Ship plates</b>	
ASTM A 131	Grade A, B, D, AH32 to EH36
<b>Cast steels</b>	
EN 10213-2	GP240R
<b>Pipe material</b>	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415, L445
API 5LX	X42, X46, X52, X60
EN 10216-1	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
<b>Boiler &amp; pressure vessel steels</b>	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
<b>Fine grained steels</b>	
EN 10025 part 3/4	S275, S355, S420

## PACKAGING DATA

Sizes Diam. x length (mm)	Current range (A)	Weight/ 1000 pcs (kg)
2.5x350	55-95	19.50
3.2x350	80-150	32.73
3.2x450	95-150	41.82
4.0x450	120-190	65.00

## REMARKS / APPLICATION ADVICE

Redry electrodes 2-4h 350 ±25°C after removal from cardboard boxes