

FOR HEAT-
RESISTING STEEL

AWS E7016-A1
JIS DT1216
KS DT1216

K-7016A1

Typical applications

Welding of alloys used for high temperature service such as C-Mo steel pipes(STPA 12, A335-P1), boiler and heat exchanger steel tubes(STBA 12, A209-T1, A161-T1), rolled steels(A204-A,B,C), cast steel(A217-WC1) and forged steels(A182-F1, A336-F1)

Coating

Low hydrogen type.

Characteristics on Usage

- ① Preheat at 100~200°C and postheat treat at 620~680°C.
- ② Redry the electrode at 350~400°C for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Mo
0.07	0.54	0.83	0.52

Typical mechanical properties of all-weld-metal

Temp.	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	PWHT
R · T 450°C	560 {57} 370 {38}	650 {66} 520 {53}	31 20	620°C × 1hr. S · R

Sizes available and recommended currents (AC or DC ⊕)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0
Length (mm)	350	350	400	400	450
Amp.	F 55~85 V&OH 50~80	90~130 80~120	140~190 110~170	180~250 130~200	240~300 -

Welding positions



Approved by