



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

USA 7016 Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION;

7016 is a low hydrogen, all position electrode used for welding heavy duty steel structures and plates. This electrode provides excellent arc stability and produces X-ray quality weld deposits with higher crack resistance, elongation and ductility than other mild steel electrodes. USA 7016 yields a beautiful bead appearance with easy slag removability. Typical applications would include strength members of ship hulls, rolling stocks, machinery, bridges, free-cutting steels, hi-sulfur steels and medium carbon steels.

TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps (Flat)	Volts
3/32"	50-100	23-27
1/8"	110-150	23-27
5/32"	150-190	24-30

Use a short arc – dragging with 10-15% from 90°

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES

Carbon	0.08	Elongation in 2" (%)	33.6
Manganese	0.98	Yield Strength (psi)	69,000
Silicon	0.48	Tensile Strength (psi)	79,000
Phosphorus	0.012	Charpy V-notch at -20°F	109 ft-lbs
Sulphur	0.010		

AVAILABLE SIZES: TE 7016 = 3/32, 1/8", 5/32"

SPECIFICATIONS; ANSI/AWS A5.1 E7016
ASME SFA 5.1 E7016

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