



GB/T 5117 E5016
AWS A5.1 E7016
EN ISO 2560 - AE42 2 B 12 H5

AK E7016

Description: A low hydrogen alkaline electrode for all positional welding with excellent welding properties, like good slag detachability and beautiful weld appearance, suitable for short arc welding.

Application: Used to weld the Marine steels (A 、 B 、 D 、 E 、 AH36 、 DH36 EH36) and other same grade strength structures, like vehicles, bridges, constructions, etc..

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Ni	Mo	Cr	V
Requirement	0.15	0.75	1.6	0.035	0.035	0.030	0.30	0.020	0.08
Actual Result	0.068	0.51	1.13	0.008	0.018	0.007	0.008	0.018	0.015

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	490-660	≥400	≥ 17	≥47J(-30℃)
Actual Result	550	446	28	120

Recommended welding parameters:

Diameter / mm		2.5	3.2	4.0
Welding current / A	F/ H	70-110	100-140	140-180
	V/OH	50-80	80- 110	130- 170