Product Data Sheet

BASIC COATED LOW HYDROGEN ELECTRODE

BRAND NAME VJ 7016

AWS/ASME Class E 7016

SPECIFICATION SFA 5.1 IS 814 : EB 5324H2X

Features and Applications :

VJ 7016 is a basic-coated low-hydrogen electrode designed for welding restrained joints subjected to dynamic loading. The weld deposit is of radiographic quality, offering excellent resistance to hot cracking and superior notch toughness at sub-zero temperatures. It is particularly suitable for welding mild steel, medium and high tensile steels, low alloy steels, steel of unknown composition, and for machinable welds on cast iron. This electrode is commonly used in a variety of industries, including boilers, pressure vessels, heat exchangers, oil refineries, and chemical and food industries. It is also well-suited for applications in storage tanks, earthmoving equipment, railways, structural components such as cranes, tractors, rollers, shipbuilding, conveyor systems, and pipelines.

CHEMICAL COMPOSITION :

All Weld Metal (%)	
TYPICAL	**Max**
C	0.15
Mn	1.60
Si	0.75
S	0.035
P	0.035

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal - As Welded	
Properties	**Typical**
YS (MPa)	450
UTS (MPa)	570
El (%)	27
Charpy V at -30°C (J)	120

DIMENSIONS & CURRENT DATA

Dimension (mm)	Current (A)		Packing (kg)
Dia x Length	**Min**	**Max**	**Qty / Pkt**
2.50 x 350	60	90	3.5
3.15 x 450	90	140	4.5
4.00 x 450	150	190	4.5
5.00 x 450	190	260	4.5

CURRENT : DC (+)

WELDING POSITION:

OTHER DATA:

Redrying: The electrodes should be redried at 250°C for 1 hour.