

# Pipelin<sup>®</sup>er 16P

## TOP FEATURES

- DC- (DCEN) is the recommended polarity for root pass welding on pipe

## CLASSIFICATION

AWS A5.1 E7016-H4, E7016-1 H4

## CURRENT TYPE

AC/DC+

## WELDING POSITIONS

All position, except vertical down

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S
0.06	1.3	0.5	0.013	0.009

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
					-29°C / -30°C	-40°C
Required: AWS A5.1		min. 400	min. 490	min. 22	min. 27	
Typical values	AW	470	590	26	120	90

AW = As welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	55-105
3.2 x 350	75-135
4.0 x 350	120-170

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CAN	-	4.5	ED033835
	CAN	-	22.7	ED030916
3.2 x 350	CAN	-	4.5	ED033836
	CAN	-	22.7	ED030917

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.