

# Lincoln® 7016 DR

## Key Features

- Double Coated Basic Electrode
- Very stable arc, insensitive to the effects of arc blow
- Excellent operator appeal
- Good X-ray soundness and start/restart behaviour
- Exceptional wetting even at low amperages
- High penetration
- Premium electrode made in Europe

## Typical Applications

- Suitable for welding prequalified procedures for steel groups 1-7C according to AS/NZS 1554.1 Table 4.6.1.
- Ideal for pipe welding in both root pass and filling
- High flexibility for irregular gaps

## Conformances

<b>AWS A5.1:</b>	E7016-H8
<b>AS/NZS 4855-A:</b>	E 38 3 B 12 H10
<b>AS/NZS 4855-B:</b>	E 4916 A U H10
<b>BV:</b>	3YH10
<b>DNV-GL:</b>	3Y40H10
<b>LRS:</b>	3YmH10

## Welding Positions



## Diameter / Packaging

Diameter mm	Length mm	Part Number	Packaging
2.5	350	829275	CB 3.9 kg (3 x CB per carton)
3.2	350	829276	CB 4.1 kg (3 x CB per carton)

## Mechanical Properties - As required per AWS A5.1

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
<b>Typical Results - As Welded</b>	380 min	470-600	26 min	≥60

## Deposit Composition

	%C	%Mn	%Si	Diffusible Hydrogen%S
<b>Typical Results - As Welded</b>	0.08	1.20	0.6	5 ml / 100 g

## Typical Operation Procedures

Polarity	Current (amps)	
	2.5mm	3.2mm
AC / DC+	55-95	80-150