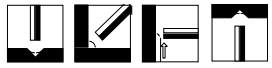


RD-716A	BASIC LOW HYDROGEN ELECTRODE FOR WELDING C-Mn-Mo STEELS OPERATING UP TO 450°C				DATA SHEET NO. 45		
SPECIFICATION	AWS A5.5	BS EN ISO 2560-B		JIS Z 3223			
CLASSIFICATION	E7016-A1	E4916-1M3		DT 1216			
WELDING FEATURES OF THE ELECTRODE	<p>The chemical nature of the flux together with its controlled coating factor allows the electrode to be used at relatively low amps. This factor together with the fairly fluid but quick freezing slag facilitate vertical up welding including controlled penetration root runs.</p> <p>Overall the arc is very stable, slag detachability is good, fillet welds are slightly convex and metal recovery is some 98% with respect to weight of the core wire.</p>						
PRODUCT DESCRIPTION	<p>The design emphasis of the chemically basic flux is engineered to ensure the optimum weld metal properties demanded by the specification are fully met.</p> <p>The basic flux containing the appropriate alloying elements but minimal iron powder, is extruded onto a high purity ferritic core wire and bound with a blend of silicates that ensure both coating strength and a coating resistant to subsequent moisture absorption.</p>						
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Nominal 0.5Mo content improves elevated temperature performance of weld metal over C-Mn types operating at 450°C.</p> <p>Materials to be welded include: ASTM A335-P1 A209 and A250-TI BS3059-243-3606-243-245 2U Forged ASTM A336-F1 A204 A, B and C. Cast ASTM A217-WC1 A352-LC1</p>					<p>PRE-HEAT 50 – 250 °C DEPENDING ON THICKNESS AND RESTRAINT</p>	
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Mo Fe
	MIN	-	-	-	-	-	0.40
	MAX	0.12	0.9	0.6	0.03	0.03	0.65
	TYPICAL	0.05	0.8	0.4	0.01	0.01	0.50 Bal.
ALL WELD METAL PROPERTIES	<u>PROPERTY</u>		<u>UNITS</u>	<u>MINIMUM</u>	<u>TYPICAL</u>	<u>OTHERS</u>	
	Tensile strength		N/mm ²	490	580	PROPERTIES MAINTAINED AFTER PWHT AT 620°C	
	0.2% Proof stress		N/mm ²	390	490		
	Elongation on 4d		%	22	28		
	Reduction of Area (RA)		%	-	-		
	Impact energy -30°C		J	-	80		
WELDING AMPERAGE AC or DC+	Ø (mm)	2.6	3.2	4.0	5.0		
	MIN	50	75	130	180		
	MAX	85	125	170	220		
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.						
RELATED PRODUCTS	Please contact our Technical Department for detail.						