



LKE-7016

LINKWELD ALLOYS INC.

AWS	A5.1 E7016
EN	EN499 E 42 2 B 1 2
JIS	Z3212 D5016

Characteristics:

LKE-7016 is a low hydrogen type electrode for the welding of high tensile steel. The welding can be done with stable arc, less spatters, good slag removability, good slag covering and good X-ray soundness.

Applications:

It is suitable for low alloy steels, medium carbon steels, heavy steel plates, cast steels and steels of poor weldability. Due to good X-ray and mechanical properties, LKE-7016 is used for skill testing and competition by choice.

Notes on Usage:

1. Dry the electrodes at 300-350°C for 60 minutes, and keep at 100-150°C before use.
2. Take the backstep method to prevent blowholes at the arc starting.
3. Keep the arc as short as possible.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.080	1.0	0.53	0.012	0.008

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV , J	
			0°C	-29°C
490	560	31	225	163

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		2.6	3.2	4.0	5.0
Length (mm)		300	350	400	400
		350	400	450	450
Amps	F	55-85	90-130	130-180	180-240
	V&OH	50-80	90-120	130-160	160-200
Weight per pack(kg)		4/5	5	5	5
Weight per carton (kg)		20	20	20	20