



## **M-90 E7016**

### **FEATURES**

- \*SUITABLE FOR BUTT AND FILLET WELDING OF HEAVY STRUCTURE
- \*GOOD CRACK RESISTANCE AND X-RAY PERFORMANCE
- \*GOOD MACHANICAL PROPERTIES
- \*LOW FUME

### **APPLICATION**

- \*HEAVY STEEL FABRICATION
- \*SHIPBUILDING
- \*PRESSURE VESSEL

### CLASSIFICATION

- \*AWS/A5.1/ASME SFA5.1 E7016

### **CHEMICAL COMPOSITIONS**

C	Si	Mn	P	S	CR	Ni	MO
0.08	0.62	1.22	0.16	0.11			

### **MECHANICAL PROPERTIES**

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2 )	N/mm2 (lbs/in 2 )	(%)	oC ( oF)	J (ft lbs)
560 (81,300)	641 (93,100)	28.4	-30(-22)	80(59)

### **WELDING PARAMETERS**

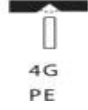
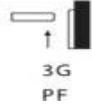
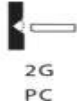
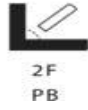
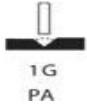
DIAMETER (mm)	2.5	3.2	4
LENGTH (mm)	350	350	400
CURRENT (amps)	55-85	90-130	130-180

### **CURRENT**

- \*AC or DC +

# WELDING POSITIONS

ASME:  
ISO 6947



## Current

