

NST 7016 S

AWS: SFA5.1 E 7016

EN 499: E 38 2 B 12 H10

DIN 1912 E 51 43 B R 10



Basic electrode for low and unalloyed steels of up to 600N/mm².

General description:

NST 7016 S is a multi-purpose electrode suitable for assembly work, workshop and repair welding. Smooth and clean welds which blend into base metal reducing the chances of undercut. Excellent gap bridging properties. Due to its double covering, the electrode has a stable and concentrated arc and is therefore ideally suited for root pass and positional welding.

Welding positions:



Welding current:

DC+/AC

Redrying:

330 °C/2 hours.

Typical chemical composition of all-weld-metal:

C	Si	Mn							
0,06	0,70	0,90							

Diffusible hydrogen content (ml/100g):

Mechanical properties of all-weld-metal:

Yield and Tensile Strengths			Charpy Impact Test	
Yield Mpa	Tensile Mpa	Elongation %	Charpy V (J) -20 °C	
≥380	470-600	≥20	≥100	

Guidance - Ampere (DC+/AC):

2,0 mm	2,5 mm	3,2 mm	4,0 mm
55-65 A	60-90 A	90-150 A	140-190 A

Packaging information:

2,0 x 300 2,0kg pack , carton 12,0kg
2,5 x 350 2,0kg pack , carton 12,0kg
3,2 x 450 2,3kg pack , carton 13,8kg
4,0 x 450 2,6kg pack , carton 15,6kg

Approvals:

VdTÜV, CE

Reference / date:

NST 7016 S,
English, 11.09.2018.

Perfect Welding

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