DURAMAX®
Inspiring the future generations of welders

Product Data Sheet

DM7016 Premium Electrode

Classification: **E7016**

AWS A 5.1 / ASME SFA 5.1

DuraMax DM7016 is a LOW HYDROGEN POTASSIUM COATED TYPE WELDING ELECTRODE

CHARACTERISTICS, FEATURES & APPLICATIONS

DURAMAX E7016 is a hydrogen controlled basic coated electrode for welding medium and high tensile structures, grey cast iron components, low and medium carbon steels. The deposits are of radiographic quality coupled with excellent mechanical properties. DM7016 is suitable for overlaying buffer layer before hardfacing, joining mild steel to carbon steel. Uses include blast furnace, drilling rigs and flat forms, industrial & mining machinery, bridges, boiler fabrication, machinery for earth moving and road equipment.

RE-DRY CONDITIONS: Re-Dry the electrode at 250°C for one hour before use.

Typical All Weld Chemical Composition (%)

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.15 max	1.60 max	0.75 max	0.035 max	0.035 max	0.30 max	0.20 max	0.30 max	0.08 max
Mn + Ni + Cr + Mo + V = 1.75 max								

All Weld Mechanical Properties

UTS (N/mm²)	YS (N/mm²)	EL % (1=4d)	CVN Impacts (J) @ -30°C
490 min	400 min	22% min	50 - 100 J

Sizes available and recommended currents (DC +) or AC 70V

SIZE	3/32	1/8	5/32	3/16
AMPS	65 ~ 110	100 ~ 150	140 ~ 200	180 ~ 255

POLARITY: DCEP or AC 70V
DCEP: DC, Electrode Positive (reverse polarity) has the most weld penetration
AC: medium weld penetration (can be more spatter)
WELDING POSITIONS: Flat, Horizontal, Overhead, Vertical-up and Vertical-down positions
USE LESS AMPS ON THIN METAL; MORE AMPS ON THICK METALS

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The above information is to be use as a guideline and is taken directly from the manufacturers Technical Data Sheet. If additional information is needed please contact (800) 692-5930