Stanvac INTERNATIONAL

Product Data Sheet

C-Mn and low-alloy steels

STAVINOX 7016 S

- ★ Ultra smooth finely rippled weld beads.
- ★ Less than 4.0 ml diffusible hydrogen.
- ★ Excellent impact notch toughness in class.
- ★ Superior reliability for the critical welding of C-Mn microlloyed & low alloy structural steels.

Classification

AWS A5.1: E 7016-1 H4 ***EN 499*:** E 42 5 B 12 H5

EN ISO 2560-A: E 42 5 B 1 2 H5

Description and applications

Basic coated, low hydrogen electrode for producing tough and crack-free welded joints. Good operating characteristics when positional welding. Excellent for joints access making electrodes suitable for root joint welding. Weld metal has good toughness properties down to -50°C. Suitable for offshore, petrochemicals and power engineering industries.

Base materials

S(P)235-S(P)420; GP240-GP280; L245-L360

Typical weld metal Chemical Composition (%)

C	Si	Mn	P	S
0.07	0.30	1.40	0.025	0.020

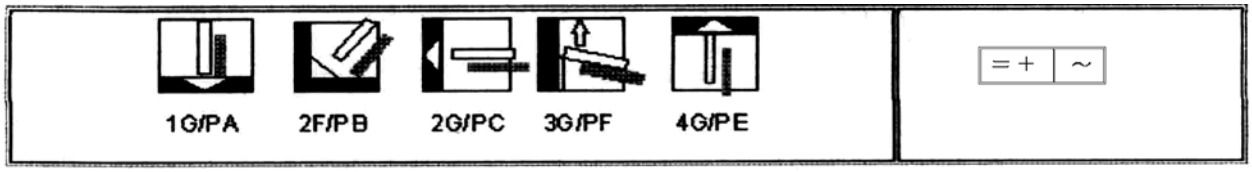
All weld metal mechanical properties (typical)

Heat Treatment	Tensile Strength R_m (N/mm^2)	Yield Strength R_m (N/mm^2)	Elongation A_5%	Impact Energy ISO-V(J)- 45°C	Hardness
As welded	550-620	450	30	70	--

Amperes (A)

2.50	3.15	4.00	5.00
60-80	100-130	140-170	180-220

Storage and Redrying : Keep dry and avoid condensation,
HD≤5: Re-dry at 340-360°C for 1 hours, 3 times max.
HD≤10: Re-dry at 300-350°C for 2 hours, 3 times max,



Revised on: 02/12/2025

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STANVAC INTERNATIONAL LTD.
Corporate Office: 551, Sector-37, Pace City-II, Gurgaon, Haryana – 122001, India
Ph : +91-9818035558
E-mail : mkp@stanvac.com Web site : www.stanvac.com