

OK 53.16 SPEZIAL

SMAW

Type Basic

E7016

Description

OK 53.16 is a double-coated electrode combining the running characteristics of a rutile electrode with the mechanical properties of a basic electrode. OK 53.16 welds on both AC and DC and the spatter loss is minimal.

Recovery

105%

Welding current

DC+, AC OCV 50 V



Classifications

SFA/AWS A5.1	E7016
EN 499	E38 2 B 32 H10
ISO 2560	E 51 4 B 21(H)

Typical all weld metal composition, %

C	Si	Mn
0.07	0.6	0.9

Typical mech. properties all weld metal

Yield stress, MPa	450
Tensile strength, MPa	530
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	120

Approvals

ABS	3, H10, 3Y
BV	3, 3YHH
CL	EN 499
DB	10.039.29
DNV	3YH10
DS-EN 499	E 38 2 B 32 H10
GL	3YH10
LR	3, 3YH10
UDT-EN 499	E 38 2 B 32 H10
VdTÜV	02762

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	50-90	26	0.63	77	0.86	54
3.2	350	90-150	25	0.65	46	1.4	57
4.0	450	120-190	26	0.64	24	1.9	79
5.0	450	160-230	26	0.63	15	2.4	99