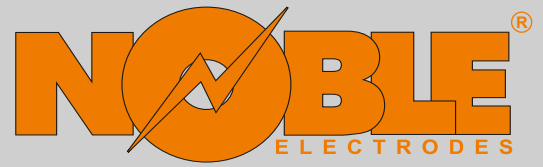


# NOBLE - 7016

Mild Steel Low Hydrogen type Radiographic  
Quality Electrodes



## CLASSIFICATION

**AWS - A5.1: E7016**

**Characteristics :** **NOBLE - 7016** is a medium-heavy coated, basic, low hydrogen type electrode for the welding of mild-steel, medium-high tensile and low-alloy steel. It gives sound radiographic quality welds having excellent mechanical properties. It also gives good penetration and its slag is easily detachable and provides smooth bead finish.

**Applications :** **NOBLE - 7016** is suitable for the welding of mild steel, medium high tensile steels. It is also used for joining cast steel to mild steel and as buffer layer before hard facing of the surface. Its other applications are boilers, pressure vessels, shipping, oil tanks railways etc...

## Mechanical Properties

| Mechanical Tests      | AWS Specifications           |
|-----------------------|------------------------------|
| Yield Strength        | 400 N/mm <sup>2</sup> (Min.) |
| Tensile Strength      | 510 - 610 N/mm <sup>2</sup>  |
| Elongation            | 20 % (Min.)                  |
| Impact (CVN) at -30°C | 27 J (Min.)                  |

\* If Moist: Re-dry at 250°C For 2 Hrs.

## Weld Metal Chemistry (%)

| Elements | C           | Mn          | Si          | P            | S            | Ni          | Cr          | Mo          | V           |
|----------|-------------|-------------|-------------|--------------|--------------|-------------|-------------|-------------|-------------|
| Range    | 0.10<br>Max | 1.60<br>Max | 0.75<br>Max | 0.035<br>Max | 0.035<br>Max | 0.30<br>Max | 0.20<br>Max | 0.30<br>Max | 0.08<br>Max |

## Packing Specifications & Current Condition

| Size<br>(mm) | Pkts. / Case | Pcs. / Pkt | Current (Amp.)<br>AC (50V) DC (+) |
|--------------|--------------|------------|-----------------------------------|
| 2.50 x 350   | 04           | 200        | 70 - 100                          |
| 3.15 x 350   | 04           | 125        | 100 - 140                         |
| 3.15 x 450   | 04           | 125        | 100 - 140                         |
| 4.00 x 450   | 04           | 70         | 140 - 180                         |
| 5.00 x 450   | 04           | 55         | 170 - 240                         |

*“Noble – Characterized by all Excellent Qualities”*