

Product Name	KangarooArc 7016
Item Number	KA7016

KangarooArc 7016, a heavy coated electrode specifically designed for welding medium to high tensile structural steels. Suitable for all positional welding (except vertical down). This low hydrogen type electrode excels in joining and surfacing high strength steels, including Carbon Steel up to 0.4% C, Manganese Steel up to 2.0% Mn, and Chromium Steel up to 0.4% C and 0.6% Cr. The double coating of this electrode ensures a concentrated and stable arc, enhancing its user-friendliness. The product is vacuum-sealed, to retain its low hydrogen quality and minimising the need for redrying in most applications. However, for best results, it is still recommended to re-dry the electrodes at 250°C to 300°C for 2 hours before use.

Applications:

Building structures, Rail coaches and wagons, steels of unknown composition, Welding cast iron, and Welding buffer layer before hard facing, Earth moving machinery etc.

Typical Weld metal Composition:

Element	Percent
C	0.060
Mn	1.10
Si	0.50
P	0.022
S	0.017

Typical Mechanical Properties of all weld Metal:

Ultimate Tensile Strength N/mm2	Yield Strength N/mm2	Elongation % (L=5d)	CVN Impact Values at 0 OC. J
570	490	24	80 J

Classifications:

AWS/ A5.1: E	E 7016
AS / NZS 4855 -B	E4916 A U H10
I SO 2560-A	E42 3 B12 H5

Current Range & Packing Data:

Size MM D x L	Current Range (Amps) AC or DC (+)	Pieces per 2.5 Kg Packet (Approx)	Pieces 20 Kg Case (Approx)
2.50x350	60-90	105	840
3.20x450	90-140	53	424
4.00x450	140-180	35	280
5.00x450	170-200	23	184

Welding Instructions: - For best results Re-Dry the electrodes at 250° C to 300°C for 02 hrs.

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