



## LOW HYDROGEN ELECTRODES

### PREMIER-7016

#### CHARACTERISTICS :

PREMIER-7016 is a heavy coated, all position, low hydrogen type electrode for the welding of medium high tensile structural steels, joining and surfacing of high strength steels such as Carbon Steel upto 0.4% C, Manganese Steel upto 2.0% Mn and Chromium Steel upto 0.4% C and 0.6% Cr. PREMIER-7016 is highly recommended for use on structures subject to impact and dynamic loading under severe service conditions.

#### APPLICATIONS :

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

#### TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.075
Mn	0.32
Si	1.23
P	0.017
S	0.022

#### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

Ultimate Tensile Strength Kg/mm <sup>2</sup>	Yield Strength Kg/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Strength at -20 °C. Kgm
57	48	26	8

### PREMIER-7018

#### CHARACTERISTICS :

PREMIER-7018 is a heavy coated, all position, low hydrogen type electrode, designed for welding of structural steels, high strength low-alloy steels, boiler plates and also low temperature steels. It permits crack resistant welding of high carbon steels. It produces high purity, radiographic quality weld deposits with excellent non-ageing properties. Deposition efficiency is about 115%.

#### APPLICATIONS :

Structural steels, Low alloy steels, Low temperature steels, High carbon steels, Rails, Wagons, Bridges, Boilers, Pressure vessels, Tanks, Ship-building, Cranes, Machine building etc. involving joining of dissimilar steels and welding of heavy mild steel sections. Specially recommended for heavy joints under restraint and subject to dynamic loading.

#### TYPICAL WELDMETAL COMPOSITION :

Element	Percent
C	0.063
Si	0.68
Mn	0.95
S	0.019
P	0.020

#### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

Ultimate Tensile Strength Kg/mm <sup>2</sup>	Yield Strength Kg/mm <sup>2</sup>	Elongation % (L=5d)	CVN Impact Strength at -20 °C. Kgm
61	51	28	8.5

#### CLASSIFICATION :

AWS A5.1	:	E 7016
IS	:	EB 5126 H 2 X
DIN 1913	:	E 5126 B 10
BS 639	:	E 5126 B 24 (H)

#### CURRENT RANGE & PACKING DATA:

Size MM DxL	Current Range (Amps) AC (70V) or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	240-320	30	120
5.00x450	190-240	50	200
4.00x450	140-190	75	300
3.15x450	100-140	120	480
2.50x350	60-100	235	940

Or, 5Kg per Packet and 4 Packets per Carton.

#### CLASSIFICATION :

AWS A5.1	:	E 7018
IS	:	EB 5226 H 3 JX
DIN 1913	:	E 5226 B 10 120
BS 639	:	E 5226 B 120 24 (H)

#### CURRENT RANGE & PACKING DATA :

Size MM DxL	Current Range (Amps) AC (70V) or DC (+)	Pieces per Packet	Pieces per Carton
6.30x450	240-320	25	100
5.00x450	190-240	40	160
4.00x450	140-190	70	280
3.15x450	100-140	100	400
2.50x350	60-100	150	600

Or, 5Kg per Packet and 4 Packets per Carton.

Approved By:

**Lloyds Register of Shipping (LRS)  
American Bureau of Shipping (ABS)  
Bureau Veritas (BV)**