euromarc
ELITE

ELECTRODE
Basic Low Hydrogen – E7016

705

GENERAL DESCRIPTION

Elite 705 is a Basic 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..

- Exceptional arc stability
- Ultra-low diffusible hydrogen level : 4ml /100gms weld metal
- Superior reliability for the critical welding of C-Mn microlloyed & low alloy structural steels.
- Excellent impact notch toughness
- Minimal spatter
- All Positional except vertical down
- Vacuum packed

WELDING POSITIONS



CLASSIFICATION

AS/NZS 4855-B-E4916 AU H5
EN ISO 2560 A E 42 5 B 12 H5
AWS: A 5.1 : E7016 H4

CHEMICAL COMPOSITION

Wt% -	Si	C	Mn	P	S
wire	0.40	0.06	1.30	0.025	0.020

TYPICAL MECHANICAL PROPERTIES

Typical as welded	
Yield Strength	420 MPa
Tensile strength	550-620 MPa
Elongation A5(%)	30%
Impact Energy	100J @-30°C

DEPOSITION DATA – AC / DC (+)

	2.5mm	**3.2mm**
Current (A)	50-80A	90-130A
Voltage (V)	Determined by arc current and electrode arc length.	

Welding parameters are a guide only as they are dependent on the machine used, material thickness and operator experience.
No data is to be construed as a recommendation for any welding condition or technique by Euromarc.

CONFORMANCE AND APPROVAL

CE
LR
TUV
DB

REBAKING

Re-baking is not necessary if the package is intact.
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,

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STORAGE
Store open packets in a heated cabinet.

WARNING
Electric shock can kill. Arc rays can injure eyes. Welding fumes are hazardous to your health and may damage lungs and other organs. Use adequate ventilation. Arc rays and sparks can injure eyes and burn skin. Wear correct hand, head, eye and body protection. Read and understand the Safety Data Sheet for this product.

PACKAGING INFORMATION				
Size	**Weight**	**Length**	**Vacuumed Packed**	**Part Number / Order code**
2.5mm	2kg	350mm	Yes	VE70525302
3.2mm	2kg	350mm	Yes	VE70532305

