



## Unibraze 7016 (E7016)

### CONFORMANCES AND APPROVALS:

AWS A5.1, E7016

### DESCRIPTION:

UNIBRAZE 7016 is a basic coated electrode for making vertical-down fillet joints with a flat appearance at high speed. The slag is of the self-lifting type. UNIBRAZE 7016 is especially good on AC and is used in shipbuilding and structural engineering.

### APPLICATIONS:

Shipbuilding and structural engineering.

### FEATURES:

- Smooth, stable arc
- Slag detaches easily
- Welds in the flat, horizontal, vertical down positions

### BENEFITS:

- Easy to use, good control
- Increased deposition rate, faster travel
- Fast clean-up, good bead appearance

### TYPICAL WELD METAL PROPERTIES:

#### Weld Metal Analysis

Carbon (C)	0.085
Manganese (Mn)	0.54
Silicon (Si)	0.50

### TYPICAL MECHANICAL PROPERTIES (AW):

Tensile Strength	74,000 psi (510 MPa)
Yield Strength	60,915 psi (420 MPa)
Elongation % in 2"	24.0%

#### AWS Spec: (min)

70,000 psi (490 MPa)
58,000 psi (400 MPa)
22.0%

### TYPICAL CHARPY-V-NOTCH IMPACT VALUES:

Avg. at -4°F (-20°C)	59 ft•lbs (80 Joules)
Avg. at -40°F (-40°C)	34 ft•lbs (47 Joules)

#### AWS Spec: (min)

20 ft•lbs @ -20°F (27 Joules @ -30°C)

### TYPE OF CURRENT: AC, DCEP

### RECOMMENDED OPERATING RANGES:

3/32" (2.4 mm)	70-110 amps
1/8" (3.2 mm)	90-135 amps
5/32" (4.0 mm)	140-190 amps
3/16" (5.0 mm)	190-240 amps

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its product.