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:	**BENEFITS:**
• Smooth, stable arc	• Easy to use, good control
• Slag detaches easily	• Increased deposition rate, faster travel
• Welds in the flat, horizontal, vertical down positions	• 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):		**AWS Spec: (min)**
Tensile Strength	74,000 psi (510 MPa)	70,000 psi (490 MPa)
Yield Strength	60,915 psi (420 MPa)	58,000 psi (400 MPa)
Elongation % in 2”	24.0%	22.0%

TYPICAL CHARPY-V-NOTCH IMPACT VALUES:		**AWS Spec: (min)**
Avg. at -4°F (-20°C)	59 ft•lbs (80 Joules)	20 ft•lbs @ -20°F (27 Joules @ -30°C)
Avg. at -40°F (-40°C)	34 ft•lbs (47 Joules)	

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

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