

JACKSON ULTRA-16

BASIC COATED, LOW HYDROGEN ELECTRODE FOR
WELDING HIGH AND MEDIUM CARBON SULPHUR
STEELS.

BASIC ALLOY: FE, MN, SII
AWS/SFA-5.1: E 7016
EN ISO 2560-A E 42 3B 12

KEY FEATURES:

An electrode for welding medium and high tensile structures, grey cast iron components, low and medium carbon steels. The deposits are of radiographic quality coupled with excellent mechanical properties.

APPLICATIONS

- joining mild steel to carbon steel
- Overlaying buffer layer before hard-facing
- Boilers, Flat forms and offer drilling rigs
- Pressures vessels tanks
- Blast furnace sells

RE-DRY CONDITION:

- Re-dry the electrode at 350°C for one hour, for best results

CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.10	0.80-1.50	0.75	0.030	0.030

(Single value maximum)

MECHANICAL PROPERTIES:

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
420 min	490 min.	22 min	- 30°C : 27 J min

WELDING POSITION



1G/1F



2G/2F



3G UP



3G DOWN



4G

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (Dia)	Size(inch) (Dia)	Current Condition (DC+/AC) Amps	Kg./pkt.	KG/Case
2.50/ 2.40	3/ 32"	70-100	5	20
3.15/ 3.20	1/ 8"	100-130	5	20
4.00	5/ 32"	140-180	5	20
5.00	3/ 16"	190-230	5	20