



ULTRAMARINE

E 7016

LOW HYDROGEN, BASIC COATED ELECTRODE

Conforms to Standard AWS A5.1 E7016;
ISO 2560-B-E 4916H10

**PREMIUM
QUALITY
WELD**



Ultramarine is a low-hydrogen, basic-coated electrode suitable for construction work, boilers, and shipbuilding. It offers higher elongation percentage, greater ductility, and is primarily used in marine applications.

USAGE:



Steel Construction



Shipbuilding



Carbon Steel

KEY FEATURES:

- Spatter & Fume Formation is Low
- Excellent Strength and Ductility
- Excellent Weld Bead
- Suitable for all Position Welding
- Excellent Slag Detachability



1G/PA



2F/PB



2G/PC



3G/PF



4G/PE

Current Type: AC/DC+ (Minimum OCV 70 Volt)





TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%):

Carbon(C)	Manganese(Mn)	Silicon(Si)	Sulphur(S)	Phosphorus (P)
0.06	1.15	0.4	0.006	0.03

TYPICAL MECHANICAL PROPERTIES:

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (J)	Elongation (LO=5d0) (%)
480	570	105J at - 30°C	27

OPERATING & PACKING INFORMATION:

Dia (mm)	Length (mm)	Weight Per Packet (kg)	Recommended Current Range (A)
2.50	300	2	65–100
3.20	350	3	90–130
4.00	350	3	130–190
4.00	450	5	130–190
5.00	450	5	180–250

RULES FOR STORAGE:

- Electrodes should be stored in a moisture-free and ventilated area.
- Electrodes should be re-baked at 300°C–350°C for 90–120 minutes in a vented oven, and then stored in a holding oven at 100°C–120°C until use

SAFETY INSTRUCTIONS:



Avoid inhalation of welding fumes and gases for health and safety



Welding Arc rays can injure eyes & burn skin



Read and understand safety instructions & practices before use



Always weld in an open & well ventilated space with sufficient airflow



Wear protective safety gear for your eyes, ears & body



Always be careful when handling electrical equipment

DISPOSAL INSTRUCTIONS:

1. Dispose of packaging materials in accordance with local regulations.
2. Recycle poly or plastic components where facilities exist.
3. End pieces of electrodes can be recycled where facility exists or dispose of in accordance with local regulations, if applicable.
4. Avoid littering and improper disposal to prevent environmental pollution.

 BSRM

WIRES

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