

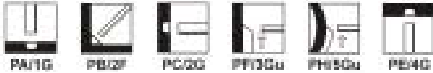
CLASSIFICATION

AWS A5.1	E7016-1 H4	A-Nr	1
ISO 2560-A	E 42 5 B 1 2 H5	F-Nr	4
		9606 FM	1

GENERAL DESCRIPTION

Basic very low hydrogen electrode (HDM < 5 ml/100g)
 Excellent for general purpose welding
 Will run on low open circuit voltage (min. OCV 55 V)
 Good side wall wetting
 Impact toughness down to -30°C
 Popular at welding schools

WELDING POSITIONS (ISO/ASME)



CURRENT TYPE

AC / DC +/-

APPROVALS

ABS	BV	DNV	LR	GL	TÜV
3H,3Y	3,3YHH	3YH5	3,3YH5	3,3YH5	+

CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	HDM
0.08	1.0	0.5	4 ml/100 g

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact ISO-V(J)	
				-20°C	-29°/-30°C
Required: AWS A5.1 ISO 2560-A Typical values	min. 400 min. 420	min. 490 500-640	min. 22 min. 20		min. 27 min. 47
AW	555	600	26	120	80

PACKAGING AND AVAILABLE SIZES

	Diameter (mm)	2.5	3.2	4.0	5.0
	Length (mm)	350	350	350	450
Carton + PE foil	Pieces / unit	136	120	90	65
	Net weight/unit (kg)	2.5	4.3	4.8	6.3

Identification Imprint: 7016 / BASO 100

Tip Color: Light blue

Baso[®] 100: rev. C-EN26-02/09/21

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectriceurope.com for any updated information.
[Download Safety datasheets \(SDS\)](#)

Baso[®] 100

EXAMPLES OF MATERIALS TO BE WELDED

Steel grades/Code	Type
General structural steels	
EN 10025	S185, S235, S275, S355
Ship plates	
ASTM A 131	Grade A, B, D, AH32 to EH36
Cast steels	
EN 10213-2	GP240R
Pipe material	
EN 10208-1	L210, L240, L290, L360
EN 10208-2	L240, L290, L360, L415, L445
API 5LX	X42, X46, X52, X60
EN 10216-1	P235T1, P235T2, P275T1
EN 10217-1	P275T2, P355N
Boiler & pressure vessel steels	
EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine grained steels	
EN 10025 part 3	S275, S355, S420
EN 10025 part 4	S275, S355, S420, S460

CALCULATION DATA

Sizes		Current type	Arc time - per electrode at max. current - (S)*	Energy E(kJ)	Dep. rate H(kg/h)	Weight/ 1000 pcs (kg)	Electrodes/ kg weldmetal B	kg electrodes/ kg weldmetal 1/N
Diam. x length (mm)	Current range (A)							
2.5x350	55-80	AC	53	116	0.8	19.1	85	1.63
3.2x350	75-115	AC	62	229	1.2	36.1	50	1.81
4.0x350	120-160	AC	64	337	1.6	50.1	34	1.72
5.0x450	160-240	AC	91	578	2.4	96.7	16	1.58
5.0x450	160-240	DC+	93	591	2.6	96.7	15	1.44

*Stub end 35mm

WELDING PARAMETERS, OPTIMUM FILL PASSES

Diameter (mm)	Welding positions					
	PA/1G	PB/2F	PC/2G	PF/3Gup	PE/4G	PH/5Gup
2.5	80A	80A	80A	90A	85A	85A
3.2	130A	125A	140A	120A	115A	120A
4.0	165A	160A	165A	150A	140A	
5.0	230A	220A	210A	200A		

REMARKS / APPLICATION ADVICE

Redry electrodes 2-4h 350 ±25°C after removal from cardboard boxes