

# S-8016.B5

Type : Basic

## Conformances

AWS A5.5/ ASME SFA5.5 E8016-B5

EN 1599 - ECrMo5 B 1 2

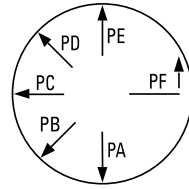
## Applications

- Low alloy steel (0.5%Cr-1%Mo)

## Features

- Good mechanical properties

## Welding Position



## Current

AC, DC ±

## Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

## Diameter / Packaging

| Diameter    | Length   | Standard   |             |
|-------------|----------|------------|-------------|
|             |          | packet     | carton      |
| mm (in)     | mm (in)  | 5kg(11lbs) | 20kg(44lbs) |
| 2.6 (3/32)  | 350 (14) |            | √           |
| 3.2 (1/8)   | 350 (14) |            | √           |
| 4.0 (5/32)  | 400 (16) |            | √           |
| 5.0 (3/16)  | 400 (16) |            | √           |
| 6.0 (15/64) | 450 (18) |            | √           |

## Typical Chemical Composition of All-Weld Metal (%)

| C    | Si   | Mn   | P     | S     | Cr   | Mo  |
|------|------|------|-------|-------|------|-----|
| 0.10 | 0.48 | 0.59 | 0.019 | 0.009 | 0.51 | 1.0 |

## Typical Mechanical Properties of All-Weld Metal

| YS<br>MPa(lbs/in <sup>2</sup> ) | TS<br>MPa(lbs/in <sup>2</sup> ) | EL<br>(%) | Heat Treatment           |
|---------------------------------|---------------------------------|-----------|--------------------------|
| 555 (80,600)                    | 663 (96,300)                    | 27.8      | 690°C(1274°F) X 1hr. S.R |

## Typical Welding Parameters / Amp.(A)

| Diameter mm (in) | 2.6 (3/32) | 3.2 (1/8) | 4.0 (5/32) | 5.0 (3/16) | 6.0 (15/64) |
|------------------|------------|-----------|------------|------------|-------------|
| Length mm (in)   | 350 (14)   | 350 (14)  | 400 (16)   | 400 (16)   | 450 (18)    |
| F & HF           | 55~90      | 90~130    | 130~190    | 190~240    | 250~300     |
| V-up, OH         | 50~80      | 80~120    | 120~170    | -          | -           |