

S-8016.B6

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E8016-B6

JIS Z3223 DT2516

EN 1599 - ECrMo5 B 1 2

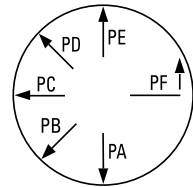
Applications

- Low alloy steel (5%Cr-0.5%Mo)

Features

- Low hydrogen type electrode
- Good creep resistance at high temperature
- Good crack resistance

Welding Position



Current

AC, DC ±

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard		Vacuum				P.V.C	
		packet 5kg(11lbs)	carton 20kg(44lbs)	packet 1.5kg(3.3lbs)	carton 15kg(3.3lbs)	packet 5kg(11lbs)	carton 20kg(44lbs)	packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	✓		✓		✓		✓	
3.2 (1/8)	350 (14)	✓		✓		✓		✓	
4.0 (5/32)	350 (14)	✓		✓		✓		✓	
	400 (16)	✓		✓		✓		✓	
5.0 (3/16)	400 (16)	✓		✓		✓		✓	

SWAW

SAW

GMW

GTAW

FCW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.57	0.85	0.005	0.004	5.45	0.02	0.51

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)	Heat Treatment
570 (82,700)	670 (97,200)	22	0 (32)	136 (100)	740°C(1364°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)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)
F	50~90	80~120	120~160	160~210
V-up, OH	50~80	70~110	90~130	-