

S-8016.G

Type : Basic

Conformances

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

JIS Z3211 E5516

EN ISO 2560-A-E46 3 1Ni B 1 2

ABS AWS A5.5 E8016-G

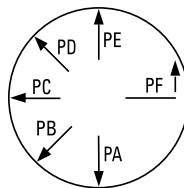
Applications

- Heavy steel fabrication
- Shipbuilding
- Offshore structure

Features

- Good bead appearance
- Good crack resistance
- Good X-ray performance
- Good mechanical properties

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 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	Ni
0.08	0.34	1.44	0.011	0.009	0.94

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)
519 (75,400)	613 (89,000)	28.8	-20 (-4)	160 (119)
			-30 (-22)	141 (104)

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	55~90	90~130	130~180	180~240	250~310
V-up, OH	50~80	85~120	110~170	150~200	-

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX