

Stick electrode

Features:

- Good CTOD properties down to -10°C
- Better impact values down to -60°C
- AC is recommended for 570 to 610MPa class steel

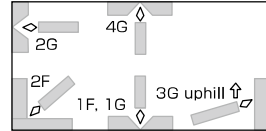
Classification: AWS A5.5 E8016-C1

Redrying Conditions: 350~400°Cx1h

Identification color: 1st Blue, 2nd Orange

Polarity: AC, DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 120H, 430L
5.0	450	5	20	97	170W, 110H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.07	0.12
Si	0.36	0.60
Mn	0.86	1.25
P	0.01	0.03
S	<0.01	0.03
Ni	2.40	2.00~2.75
Mo	0.12	-
Ti	0.018	-
B	0.0021	-

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	80~120
4.0	130~180	100~170
5.0	180~240	-

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical (AC)		Guaranty
0.2%YS (MPa)	540	530	462min.
TS (MPa)	650	640	552min.
EI on 4d (%)	27	28	19min.
IV -60°C (J)	130	120	27min.
PWHT (°C×h)	AW	608x1	AW & 605±15x1

Approvals

ABS	5YQ500 H5, MG
LR	5Y50m (H5)
DNV-GL	5Y50 H5