

**Stick electrode for 9~12%Cr-W-V-Nb steel**

**Features:**

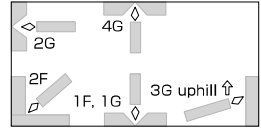
- Applied for ASTM A335 Gr. P92 and equivalents
- Excellent creep rupture strength

**Classification:** AWS A5.5 E9016-G

**Redrying Conditions:** 325~375°Cx1h

**Identification color:** -

**Polarity:** DCEP, AC

**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, 110H, 430L
5.0	400	5	20	85	170W, 120H, 430L

**Composition (all-weld metal mass%)**

	Typical (DCEP)	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.15
<b>Si</b>	0.38	0.60
<b>Mn</b>	0.94	0.50~1.50
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	0.46	1.50
<b>Co</b>	1.57	0.50~1.80
<b>Cr</b>	9.52	8.60~13.00
<b>Mo</b>	0.21	0.50
<b>V</b>	0.30	0.50
<b>Nb</b>	0.030	0.080
<b>W</b>	1.56	1.30~2.50

Note: <sup>a</sup> Single values are maximum.

**Welding parameters (A)**

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	75~115	70~110
4.0	120~160	90~150
5.0	160~220	-

**All-weld mechanical properties**

	Typical (DCEP)	Guaranty
<b>0.2%YS (MPa)</b>	650	531min.
<b>TS (MPa)</b>	700	621min.
<b>El on 4d (%)</b>	22	17min.
<b>IV 0°C (J)</b>	40	-
<b>PWHT (°Cxh)</b>	740x8	750±15x8