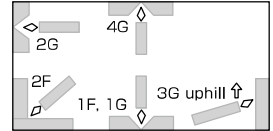


## Stick electrode

## Features:

- Suitable for 610MPa tensile strength steel
- Good impact values down to -60°C
- Excellent crack resistibility

## Welding Positions:



**Classification:** AWS A5.5 E8016-C1

**Redrying Conditions:** 350~400°Cx1h

**Identification color:** 1st White, 2nd Yellow

**Polarity:** DCEP

## 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	Guaranty <sup>a</sup>
<b>C</b>	0.06	0.12
<b>Si</b>	0.42	0.60
<b>Mn</b>	1.00	1.25
<b>P</b>	<0.01	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	2.58	2.00~2.75
<b>Mo</b>	0.12	-

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	80~120	70~110
4.0	120~170	90~160
5.0	170~230	-

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

## All-weld mechanical properties

	Typical		Guaranty
<b>0.2%YS (MPa)</b>	570	560	462min.
<b>TS (MPa)</b>	660	645	552min.
<b>EI on 4d (%)</b>	27	28	19min.
<b>IV -60°C (J)</b>	120	110	27min.
<b>PWHT (°Cxh)</b>	AW	605x1	AW & 605±15x1