

**Stick electrode for 2.25%Cr-1%Mo steel**

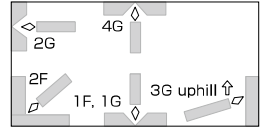
- Features:**
- Applied for ASTM A387 Gr.22 and equivalents
  - Lower tensile strength, higher impact value and less sensitive to temper embrittlement

**Classification:** AWS A5.5 E9016-B3

**Redrying Conditions:** 325~375°Cx1h

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

**Polarity:** AC

**Welding Positions:****Packaging data**

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 85H, 330L
3.2	350	5	20	31	170W, 115H, 380L
4.0	400	5	20	55	170W, 105H, 430L
5.0	400	5	20	86	170W, 115H, 430L
6.0	400	5	20	122	170W, 115H, 430L

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

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.11	0.05~0.12
<b>Si</b>	0.38	0.60
<b>Mn</b>	0.76	0.90
<b>P</b>	<0.01	0.03
<b>S</b>	<0.01	0.03
<b>Cr</b>	2.25	2.00~2.50
<b>Mo</b>	1.02	0.90~1.20

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	90~130	75~115
4.0	140~190	100~160
5.0	190~240	-
6.0	240~300	-

**All-weld mechanical properties**

	Typical		Guaranty
<b>Temp. (°C)</b>	RT	450	RT
<b>0.2%YS (MPa)</b>	510	430	531min.
<b>TS (MPa)</b>	650	510	631min.
<b>El on 4d (%)</b>	28	20	17min.
<b>IV -29°C (J)</b>	120	-	-
<b>PWHT (°C×h)</b>	690x8	690x8	690±15x1

**Approvals**

BV	UP (E9016-B3)
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