

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

**Features:** Applied for ASTM A387 Gr.22 and equivalents

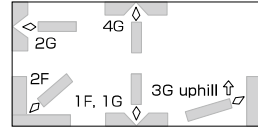
**Classification:** AWS A5.5 E9016-B3

**Redrying Conditions:** 325~375°Cx1h

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

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	270W, 85H, 330L
3.2	350	5	20	30	170W, 110H, 380L
4.0	400	5	20	55	170W, 105H, 430L
5.0	400	5	20	85	170W, 120H, 430L
6.0	400	5	20	121	170W, 120H, 430L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.05~0.12
<b>Si</b>	0.44	0.60
<b>Mn</b>	0.63	0.90
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Cr</b>	2.10	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 (AC)		Guaranty
<b>Temp. (°C)</b>	RT	450	RT
<b>0.2%YS (MPa)</b>	630	520	531min.
<b>TS (MPa)</b>	730	580	621min.
<b>El on 4d (%)</b>	22	17	17min.
<b>IV 0°C (J)</b>	120	-	-
<b>PWHT (°Cxh)</b>	690x1	690x1	690±15x1

## Approvals

<b>ABS</b>	MG (AWS A5.5 E9016-B3)
<b>LR</b>	MG
<b>DNV-GL</b>	MG (VL2Cr1Mo), H10
<b>BV</b>	UP (E9016-B3)
<b>NK</b>	MG (AWS A5.5 E9016-B3)