

Stick electrode

Features: ■ Excellent crack resistibility

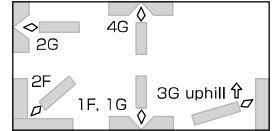
Classification: AWS A5.5 E9016-G

Redrying Conditions: 350~430°Cx1h

Identification color: 1st Brown, 2nd Silver

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	400	5	20	85	170W, 125H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.07	0.09
Si	0.68	0.40~0.80
Mn	1.13	0.75~1.35
P	0.01	0.03
S	<0.01	0.03
Ni	0.65	0.45~0.80
Mo	0.25	0.20~0.40

Note: ^a Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	80~115
4.0	130~180	110~170
5.0	180~240	150~200

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	550	531min.
TS (MPa)	650	621min.
El on 4d (%)	30	17min.
IV -18°C (J)	160	-

Approvals

NK	KMW63Y47
CCS	3Y50 H10