

Stick electrode

Features:

- Suitable for one-side welding
- Good arc stability with relatively low currents
- Excellent crack resistibility

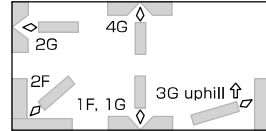
Classification: AWS A5.5 E9016-G

Redrying Conditions: 350~400°Cx1h

Identification color: 1st Blue, 2nd Yellow

Polarity: AC, DCEP, DCEN (Root pass only)

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	350	5	20	20	170W, 120H, 380L
3.2	350	5	20	30	170W, 120H, 380L
4.0	400	5	20	53	170W, 110H, 430L

Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty ^a
C	0.08	0.09
Si	0.70	0.20~0.75
Mn	1.08	0.70~1.35
P	0.01	0.03
S	<0.01	0.03
Ni	0.62	0.45~0.80
Mo	0.25	0.20~0.40

Note: ^aSingle values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G	Root pass
2.6	60~90	50~80	30~80
3.2	90~130	80~115	60~110
4.0	130~180	110~170	90~140

All-weld mechanical properties

	Typical (DCEP)	Guaranty
0.2%YS (MPa)	560	531min.
TS (MPa)	650	621min.
EI on 4d (%)	26	17min.
IV -20°C (J)	88	-

Approvals

ABS	3YQ500 H10
LR	3Y50m H10