

Stick electrode

Features:

- Suitable for butt and fillet welding
- Good impact values down to -60°C
- Ni Content is normally 1% max.

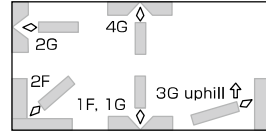
Classification: AWS A5.5 E8016-G

Redrying Conditions: 350~400°Cx1h

Identification color: 1st Purple, 2nd Green

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	270W, 90H, 330L
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 110H, 430L
5.0	450	5	20	97	170W, 105H, 480L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.06	0.10
Si	0.35	0.30~0.90
Mn	1.40	1.00~1.60
P	0.01	0.03
S	<0.01	0.03
Ni	0.93	0.70~1.0
Mo	0.10	0.05~0.15
Ti	0.018	0.005~0.035
B	0.0025	0.0005~0.0045

Note: ^a 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	80~120
4.0	130~180	110~170
5.0	180~240	150~200

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	520	510	462min.
TS (MPa)	610	590	552min.
EI on 4d (%)	33	31	19min.
IV -60°C (J)	170	140	27min.
PWHT (°C×h)	AW	605x1	AW & 605±15x1

Approvals

ABS	5YQ420 H5
LR	5Y42m (H5)
DNV-GL	5Y42 H5