

## Stick electrode

- Features:**
- Suitable for butt and fillet welding
  - Typical stick electrode in this classification

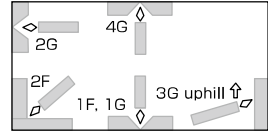
**Classification:** AWS A5.5 E9016-G

**Redrying Conditions:** 350~400°Cx1h

**Identification color:** 1st Blue white, 2nd Yellow

**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, 90H, 330L
3.2	350	5	20	30	170W, 120H, 380L
4.0	400	5	20	55	170W, 110H, 430L
5.0	400	5	20	85	170W, 120H, 430L
6.0	450	5	20	140	170W, 105H, 480L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.06	0.09
<b>Si</b>	0.66	0.40~0.80
<b>Mn</b>	1.04	0.75~1.35
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	0.61	0.40~0.75
<b>Mo</b>	0.26	0.20~0.40

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	80~115
4.0	130~180	110~170
5.0	180~240	150~200
6.0	250~310	-

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	550	531min.
<b>TS (MPa)</b>	650	621min.
<b>EI on 4d (%)</b>	30	17min.
<b>IV -18°C (J)</b>	150	-

## Approvals

<b>ABS</b>	3YQ500 H10
<b>LR</b>	3Y50m H10
<b>NK<sup>a)</sup></b>	KMW3Y50 H10
<b>CR</b>	3Y50 H10

Note: <sup>a)</sup> AC