

Stick electrode

Features: ■ Suitable for 690MPa tensile strength steel

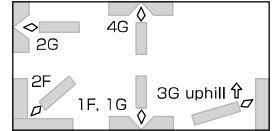
Classification: AWS A5.5 E10016-G

Redrying Conditions: 350~400°Cx1h

Identification color: 1st Blue white, 2nd Purple

Polarity: AC

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, 105H, 430L
5.0	400	5	20	85	170W, 105H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.08	0.09
Si	0.65	0.40~0.75
Mn	1.29	1.20~1.70
P	0.01	0.03
S	<0.01	0.03
Ni	1.44	1.20~1.70
Cr	0.22	0.10~0.30
Mo	0.19	0.10~0.30

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	150~220

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	660	600min.
TS (MPa)	760	690min.
El on 4d (%)	25	16min.
IV -20°C (J)	110	27min.

Approvals

ABS	MG (AWS A5.5 E10016-G)
NK	KMW3Y62 H5
CR	MG (E10016-G)