

Stick electrode

Features:

- Suitable for butt and fillet welding
- Good impact values down to -40°C
- Excellent crack resistibility

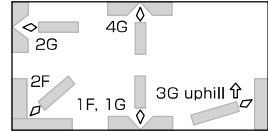
Classification: AWS A5.5 E10016-G

Redrying Conditions: 350~430°Cx1h

Identification color: 1st Green, 2nd Yellowish green

Polarity: AC

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	32	170W, 120H, 380L
4.0	400	5	20	56	170W, 120H, 430L
5.0	400, 450	5	20	87, 98	170W, 110~120H, 430~480L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.05	0.07
Si	0.38	0.20~0.60
Mn	1.21	0.80~1.40
P	0.01	0.03
S	<0.01	0.03
Ni	3.56	3.05~3.80
Cr	0.24	0.10~0.40
Mo	0.40	0.30~0.60

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	90~120
4.0	130~180	110~170
5.0	180~240	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	680	600min.
TS (MPa)	760	690min.
EI on 4d (%)	23	16min.
IV -40°C (J)	115	27min.