

## Stick electrode

## Features:

- Good CTOD properties down to -20°C
- Better impact values down to -60°C
- Excellent crack resistibility

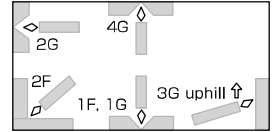
**Classification:** AWS A5.5 E9016-G

**Redrying Conditions:** 350~400°Cx1h

**Identification color:** 1st White, 2nd Yellow

**Polarity:** DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 90H, 330L
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 120H, 430L
5.0	450	5	20	97	170W, 110H, 480L

## Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.06	0.12
<b>Si</b>	0.42	0.15~0.60
<b>Mn</b>	0.97	0.60~1.20
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	2.55	2.00~2.75
<b>Mo</b>	0.12	0.30

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	70~100	65~95
3.2	80~120	70~110
4.0	120~170	90~160
5.0	170~230	-

## All-weld mechanical properties

	Typical		Guaranty	
<b>0.2%YS (MPa)</b>	560	560	530min.	490min.
<b>TS (MPa)</b>	660	640	620min.	590min.
<b>EI on 4d (%)</b>	29	28	17min.	16min.
<b>IV -60°C (J)</b>	130	112	27min.	27min.
<b>PWHT (°C×h)</b>	AW	620x1	AW	620±15x1

## Approvals

<b>ABS</b>	5YQ500 H5
<b>LR</b>	5Y50m, H5
<b>DNV-GL</b>	5Y50 H5