

## Stick electrode for 2.25%Cr-1%Mo steel

- Features:**
- Applied for ASTM A387 Gr.22 and equivalents
  - Lower tensile strength, higher impact value and less sensitive to temper embrittlement

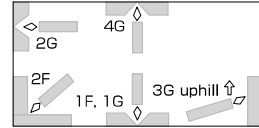
**Classification:** AWS A5.5 E9016-B3

**Redrying Conditions:** 325~375°Cx1h

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

**Polarity:** DCEP

## 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	86	170W, 115H, 430L

## Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.09	0.05~0.12
<b>Si</b>	0.24	0.60
<b>Mn</b>	0.67	0.90
<b>P</b>	<0.01	0.03
<b>S</b>	<0.01	0.03
<b>Cr</b>	2.21	2.00~2.50
<b>Mo</b>	1.02	0.90~1.20

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	75~115
4.0	140~190	100~160
5.0	190~240	-

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

## All-weld mechanical properties

	Typical		Guaranty
<b>Temp. (°C)</b>	RT	450	RT
<b>0.2%YS (MPa)</b>	500	400	531min.
<b>TS (MPa)</b>	640	480	621min.
<b>EI on 4d (%)</b>	26	19	17min.
<b>IV -40°C (J)</b>	150	-	-
<b>PWHT (°Cxh)</b>	690x8	690x8	690±15x1