

**Stick electrode for Mn-Mo and Mn-Mo-Ni steel**

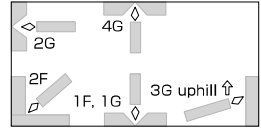
**Features:** ■ Applied for ASTM A533 Type A, B, C, D class 2 and equivalents

**Classification:** AWS A5.5 E10016-G

**Redrying Conditions:** 325~375°Cx1h

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

**Polarity:** AC, DCEP

**Welding Positions:****Packaging data**

$\phi$ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	270W, 85H, 330L
3.2	350	5	20	30	170W, 120H, 380L
4.0	400	5	20	54	170W, 120H, 430L
5.0	400	5	20	84	170W, 120H, 430L

**Composition (all-weld metal mass%)**

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.10	0.12
<b>Si</b>	0.53	0.60
<b>Mn</b>	1.41	1.00~1.60
<b>P</b>	0.009	0.020
<b>S</b>	0.005	0.020
<b>Ni</b>	0.76	0.60~1.00
<b>Mo</b>	0.50	0.40~0.65

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

**Welding parameters (A)**

$\phi$ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	-

**All-weld mechanical properties**

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	650	600min.
<b>TS (MPa)</b>	730	689min.
<b>EI on 4d (%)</b>	24	16min.
<b>IV -20°C (J)</b>	80	-
<b>PWHT (°Cxh)</b>	620x2	620±15x1