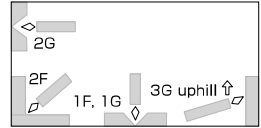


## Stick electrode for 2.25%Cr-1%Mo-V steel

- Features:**
- Applied for ASTM A542 Type D Cl.4a and equivalents
  - Excellent tensile strength at high temperatures and less sensitive to temper embrittlement

**Welding Positions:**

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

**Redrying Conditions:** 325~375°Cx1h

**Identification color:** 1st Silver, 2nd Green

**Polarity:** AC

**Packaging data**

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	32	170W, 115H, 380L
4.0	400	5	20	56	170W, 110H, 430L
5.0	400	5	20	87	170W, 120H, 430L

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

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.09	0.05~0.12
<b>Si</b>	0.28	0.20~0.50
<b>Mn</b>	0.87	0.50~1.30
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Cr</b>	2.13	2.00~2.60
<b>Mo</b>	1.03	0.90~1.20
<b>V</b>	0.39	0.20~0.40
<b>Nb</b>	0.018	0.010~0.040

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

**Welding parameters (A)**

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

**All-weld mechanical properties**

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	620	531min.
<b>TS (MPa)</b>	730	621min.
<b>El on 4d (%)</b>	24	17min.
<b>IV -18°C (J)</b>	140	-
<b>PWHT (°Cxh)</b>	705°C×8h	705±15x8