

## Stick electrode for 9%Cr-1%Mo-V-Nb steel

- Features:**
- Applied for ASTM A387 Gr.91 and equivalents
  - Excellent creep rupture strength
  - Good performance by AC current

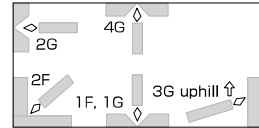
**Classification:** AWS A5.5 E9016-G

**Redrying Conditions:** 325~375°Cx1h

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

**Polarity:** AC, DCEP

## Welding Positions:



## Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 85H, 330L
3.2	350	5	20	31	170W, 115H, 380L
4.0	400	5	20	55	170W, 105H, 430L
5.0	400	5	20	85	170W, 110H, 430L

## Composition (all-weld metal mass%)

	Typical (AC)	Guaranty <sup>a</sup>
<b>C</b>	0.07	0.12
<b>Si</b>	0.39	0.60
<b>Mn</b>	1.51	2.00
<b>P</b>	0.01	0.03
<b>S</b>	<0.01	0.03
<b>Ni</b>	0.94	1.00
<b>Cr</b>	8.98	8.00~10.50
<b>Mo</b>	1.06	0.80~1.20
<b>Nb</b>	0.03	0.15
<b>V</b>	0.19	0.50

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

## Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	75~115	70~110
4.0	120~160	90~150
5.0	160~220	-

## All-weld mechanical properties

	Typical (AC)	Guaranty
<b>0.2%YS (MPa)</b>	600	531min.
<b>TS (MPa)</b>	750	621min.
<b>EI on 4d (%)</b>	25	17min.
<b>IV 0°C (J)</b>	80	-
<b>PWHT (°C×h)</b>	750x5	740±15x1

## Approvals

<b>ABS</b>	MG (AWS A5.5 E9016-G)
<b>LR</b>	MG
<b>NK</b>	MG