

Stick electrode for 5%Cr-0.5%Mo steel

Features: ▪ Applied for ASTM A387 Gr.5 and equivalents

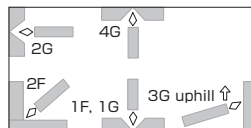
Classification: AWS A5.5 E8016-B6

Redrying Conditions: 325~375°Cx1h

Identification color: 1st Orange

Polarity: AC, DCEP

Welding Positions:



Packaging data

φ 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	82	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.08	0.05~0.10
Si	0.45	0.90
Mn	0.6	1.0
P	0.01	0.03
S	<0.01	0.03
Ni	0.03	0.40
Cr	5.3	4.0~6.0
Mo	0.56	0.45~0.65

Note: ^a Single values are maximum.

Welding parameters (A)

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

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	400	462min.
TS (MPa)	560	552min.
El on 4d (%)	33	19min.
IV 0°C (J)	150	-
PWHT (°Cxh)	750x8	740±15x1