

Stick electrode for 1-1.25%Cr-0.5%Mo steel

Features: Applied for ASTM A387 Gr.11, Gr.12 and equivalents

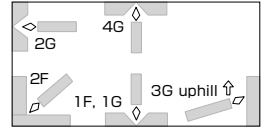
Welding Positions:

Classification: AWS A5.5 E8016-B2

Redrying Conditions: 325~375°Cx1h

Identification color: 1st Silver, 2nd Black

Polarity: AC, DCEP

**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	29	170W, 110H, 380L
4.0	400	5	20	53	170W, 115H, 430L
5.0	400	5	20	82	170W, 120H, 430L
6.0	400	5	20	122	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.06	0.05~0.12
Si	0.48	0.60
Mn	0.81	0.90
P	0.01	0.03
S	<0.01	0.03
Cr	1.31	1.00~1.50
Mo	0.55	0.40~0.65

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	80~120	75~110
4.0	125~175	100~160
5.0	185~235	-
6.0	240~300	-

All-weld mechanical properties

	Typical (AC)		Guaranty
Temp. (°C)	RT	450	RT
0.2%YS (MPa)	570	460	462min.
TS (MPa)	650	520	552min.
El on 4d (%)	26	21	19min.
IV 0°C (J)	210	-	-
PWHT (°Cxh)	690x1	690x1	690±15x1

Approvals

ABS	MG (E8016-B2)
LR	MG (E8016-B2)
DNV	NV1Cr0.5Mo, H10
BV	UP (E8016-B2)
NK	MG (E8016-B2)
TÜV	EN 1599-E CrMo1 B