

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

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

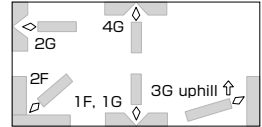
Welding Positions:

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 |