

Stick electrode

Features:

- Good CTOD properties down to -45°C
- Good impact values down to -80°C

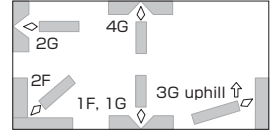
Classification: AWS A5.5 E8016-G

Redrying Conditions: 350~400°Cx1h

Identification color: 1st White, 2nd Brown

Polarity: AC

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 120H, 430L
5.0	450	5	20	97	170W, 110H, 480L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.07	0.10
Si	0.43	0.15~0.50
Mn	1.36	1.10~1.70
P	0.01	0.03
S	<0.01	0.03
Ni	1.37	1.10~1.70
Ti	0.021	0.005~0.035
B	0.0035	0.0005~0.0045

Note: ^a Single values are maximum.

Recommended welding parameters

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	150~200

All-weld mechanical properties

	Typical		Guaranty
	520	490	
0.2%YS (MPa)	520	490	462min.
TS (MPa)	610	580	552min.
EI on 4d (%)	29	29	19min.
IV -80°C (J)	127	130	-60°C: 27min.
PWHT (°Cxh)	AW	620x1	AW & 620±15x1

Approvals

LR	5Y40m (H15)
DNV	5YH10, NV2-4L, 4-4L
BV	4Y40M HH, UP
NK	KMW5Y42H10