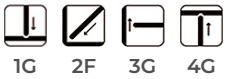
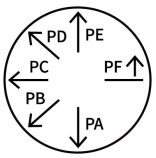
S-8016.C1

Classification

AWS A5.5/ASME SFA-5.5 E8016-C1
JIS Z 3211 E5516-N5 AP L
EN ISO 2560-A E46 5 2Ni B 1 2

Welding Positions





Features

- Good impact value at -60°C

Polarity

AC or DC +

Application Areas

- Low temperature strength steel (2.5% Ni)
- Offshore structure

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni
0.06	0.23	1.00	0.012	0.006	2.15

Typical Mechanical Properties of All-Weld Metal

PWHT	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
605°C*1hr	498(72)	606(88)	29	-60(-75)	68(50)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	55-90	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	90-130	80-120	
4.0(5/32)	400(16)	130-190	120-170	
5.0(3/16)	400(16)	180-250	-	
6.0(15/64)	450(18)	250-310	-	