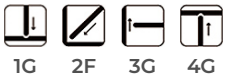
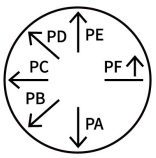
S-8016.G

Classification

AWS A5.5/ASME SFA-5.5 E8016-G
JIS Z 3211 E5516
EN ISO 2560-A E46 3 1Ni B 1 2
KS D7006 E5316

Welding Positions





Features

- Good bead appearance
- Good crack resistance
- Good X-ray performance
- Good mechanical properties

Polarity

AC or DC +

Application Areas

- Heavy steel fabrication
- Shipbuilding
- 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
0.08	0.34	1.42	0.011	0.009	0.91

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
519(75)	613(89)	29	-20(0) -30(-20)	140(103) 121(89)

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	85-120	
4.0(5/32)	400(16)	130-190	110-170	
5.0(3/16)	400(16)	190~250	150-200	
6.0(15/64)	450(18)	250-310	-	