Covered Electrodes

K-8016B6

For heat-resisting steel (5%Cr-0.5%Mo)

Classifications

EN ISO 3580-A:2008	: E CrMo5 B 12 H10	KS D 7022	: DT2516
EN ISO 3580-B:2008	: E 55 16-5CM H10	JIS Z 3223	: DT2516
AWS A5.5-06	: E8016-B6		

Description

- Covering is low hydrogen type for welding of 5%Cr-0.5%Mo steel used in oil refining and chemical industries, heat treated high tensile strength steel for aircraft part such as SAE 4130.
- Preheat at 250~350℃ and postheat treat at 750~850℃
- Excellent crack resistance because of low hydrogen contents.
- Redry the electrode at 300~400℃ for 1~2 hours prior to use.

Welding positions

Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.43	0.57	0.018	0.012	0.04	4.98	0.51	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 20℃	IV (J) 0℃	Remarks
AWS A5.5	min. 460	min. 550	min. 19			
EN ISO 3580-A	min. 400	min. 500	min. 17	≥ 47		
Example	680	740	22	55	45	PWHT

* PWHT : 740℃x1Hr

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	5.0
Length	(mm)	350	350	400	400	400
Amp. (A)	F	50~90	80~120	120~160	160~210	210~260
	V · OH	50~80	70~110	90~130	–	–

Approvals

CE