

**Classifications**

EN ISO 3580-B:2008	: E 62 15-9C1M H10	KS D 7022	: DT2616
AWS A5.5-06	: E8015-B8	JIS Z 3223	: DT2616

**Description**

- Covering is low hydrogen type for welding of super-heater tubes of high temperature and high pressure boilers, heater tubes of oil refining equipments.
- Preheat at 250~350°C and postheat treat at 750~850°C because of high self-hardening property of the deposited weld metal.
- Redry the electrode at 300~400°C 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
0.08	0.45	0.88	0.018	0.011	0.03	8.86	0.95	0.01

**Typical mechanical properties of all-weld metal**

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 460	min. 550	min. 19			
EN ISO 3580-B	min. 530	min. 620	min. 15			
Example	670	760	22	45	40	PWHT

\* PWHT : 740°Cx1Hr

**Sizes available and recommended currents (DC +)**

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F V · OH	60~90 50~60	80~120 70~110	120~160 90~150	160~220	210~260

**Approvals**

CE