Covered Electrodes

K-8016B1

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

Classifications

EN ISO 3580-A:2008 : E CrMo0.5 B 12 H10
EN ISO 3580-B:2008 : E 55 16-CM H10
AWS A5.5-06 : E8016-B1

Description

- Covering is low hydrogen type for welding of 0.5%Cr-0.5%Mo steel used high temperature high pressure boilers, chemical equipment and oil refining plants.(A335-P2, A213-T2)
- Preheat at 150~250℃ and postheat treat at 620~680℃
- 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
0.07	0.51	0.81	0.014	0.010	0.02	0.51	0.49	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. 355	min. 510	min. 22	≥ 47		
Example	590	670	26	70	50	PWHT

* PWHT : 690℃x1Hr

Sizes available and recommended currents (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0
Length (mm)	350	350	400	400	450
Amp. F	50~85	90~130	130~180	190~240	250~320
(A) V · OH	40~80	80~120	100~160	130~200	–

Approvals

CE