

Classifications

EN ISO 3580-A:2008	: E CrMo2 B 12 H10	KS D 7022	: DT2416
EN ISO 3580-B:2008	: E 62 16-2C1M H10	JIS Z 3223	: DT2416
AWS A5.5-06	: E9016-B3		

Description

- Covering is low hydrogen type for welding of 2.25%Cr-1%Mo steel used for super-heater tubes, steam pipes, heaters of boilers for thermolectric power plant and equipments oil refining industries.
- Preheat at 150~300°C and postheat treat at 680~730°C
- Excellent crack resistance because of low hydrogen contents.
- 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	0.78	0.016	0.011	0.03	2.37	1.03	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. 530	min. 620	min. 17	≥ 47	40	PWHT
EN ISO 3580-A	min. 400	min. 500	min. 18			
Example	620	710	24	55	40	PWHT

* PWHT : 690°Cx1Hr

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp.	F	60~100	90~130	130~190	190~240
(A)	V · OH	60~90	75~115	110~170	—

Approvals

CE