

Classifications

EN ISO 3580-A:2008	: E CrMo1 B 12 H10	KS D 7022	: DT2316
EN ISO 3580-B:2008	: E 55 16-1CM H10	JIS Z 3223	: DT2316
AWS A5.5-06	: E8016-B2		

Description

- Covering is low hydrogen type for welding of 1.25%Cr-0.5%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
0.06	0.47	0.65	0.014	0.012	0.03	1.31	0.52	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	≥ 47		
EN ISO 3580-A	min. 355	min. 510	min. 22			
Example	570	650	26	80	60	PWHT

* PWHT : 690°Cx1Hr

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. (A)	F V · OH	60~90 50~80	80~120 75~110	130~180 100~160	180~230 -	240~300 -

Approvals

CE