

S-8016.B2

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E8016-B2
JIS Z3223 E5516-1CM
EN 1599 - E CrMo1 B 1 2

Applications

S-8016.B2 can be used for welding of 1.25%Cr-0.5%Mo steel for super-heat tubes, steam pipes and heaters of boilers for thermo-electric power plant and equipment of oil refining industries.

Characteristics on Usage

S-8016.B2 is a low hydrogen type electrode and is usable in all positions.
It is suitable for welding 1.25%Cr-0.5%Mo steel pipes and high carbon Cr-Mo steel.

Notes on Usage

- ① Preheat at 150~300°C(302~572°F) and postheat at 670~730°C(1238~1346°F).
- ② Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ③ Keep the arc as short as possible.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.07	0.51	0.66	0.012	0.008	1.22	0.54

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
537 (78,000)	622 (90,300)	29.8	690°C(1274°F) × 1hr. S.R

Approval

ABS

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm(in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F	55~90	90~130	130~190	190~240	240~300
V-up, OH	50~80	80~120	120~170	-	-