S-8016.G

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E8016-G
JIS Z3211 E5516
EN ISO 2560-A - E46 3 1Ni B 1 2

Applications

S-8016.G can be used for welding of high tensile steel, such as buildings, bridges and shipbuilding.

Characteristics on Usage

- Extremely soft stable arc.
- Smooth bead appearance.
- No undercut formation.
- Faster deposit rate hence, more economical .
- Good crack resistance of weld metal.
- Good mechanical properties and X-ray performance.

Notes on Usage

① Dry the electrodes at 350~400 ℃(662~752℉) for 60 minutes before use.
② Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blow hole at the arc starting.
③ Use wind screen against strong wind.

Welding Position

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

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.08	0.34	1.44	0.011	0.009	0.94

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
519 (75,400)	613 (89,000)	28.8	-20 (-4) -30 (-22)	160 (119) 141 (104)

Approval

ABS

I Packing

Packet 5 ㎏ (11 lbs)
Carton 5 ㎏ (11 lbs) × 4 : 20㎏(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	130~180	180~240	250~310
V-up, OH	50~80	85~120	110~170	150~200	-