S-8016.B1

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E8016-B1
EN 1599 - E CrMo0.5 B 1 2

Applications

S-8016.B1 can be used for welding of 0.5%Cr-0.5%Mo steel used for high temperature and high pressure boilers, chemical equipment and oil refining plants.

Characteristics on Usage

S-8016.B1 is a low hydrogen type electrode which is suitable for welding 0.5%Cr-0.5%Mo steel used at high temperature. The crack resistibility of all-weld metal is excellent.

Notes on Usage

① Preheat at 150~250℃(302~482℉) and postheat at 628~680℃(1162~1256℉).
② Dry the electrodes at 350~400℃(662~752℉) for 60 minutes before use.
③ Keep the arc as short as possible.

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	Cr	Mo
0.05	0.57	0.85	0.012	0.005	0.51	0.51

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Heat Treatment
505 (73,300)	589 (85,500)	31.0	690℃(1274℉)×1hr. S.R

Approval

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	130~190	190~240	250~300
V-up, OH	50~80	80~120	120~170	-	-