

S-10016.G

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E10016-G

JIS Z3211 E6916-N4CM1 U

EN 757 E55 0 B 1 2

ABS AWS A5.5 E10016-G

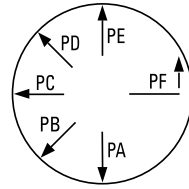
Applications

- Heavy steel fabrication
- Pressure vessels
- Power plant

Features

- Good crack resistance
- Good X-ray performance
- Good mechanical properties

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.07	0.69	1.41	0.013	0.012	1.49	0.12

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
710 (103,130)	762 (110,680)	24.0	0 (32)	110 (81)

Typical Welding Parameters / Amp.(A)

Diameter 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	170-240	250-310
V-up, OH	50-80	85-120	110-170	150-200	-