

S-8016.C2

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E8016-C2

JIS Z3211 E5516-N7 AP L

EN ISO 2560-A-E46 6 3Ni B 1 2

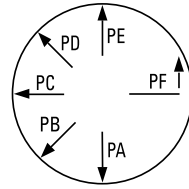
Applications

- Low temperature strength steel (3.5% Ni)
- Offshore structure

Features

- Good impact value at -60~-75°C

Welding Position



Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter	Length	Standard	
		packet	carton
mm (in)	mm (in)	5kg(11lbs)	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
0.06	0.50	0.90	0.011	0.006	3.20

Typical Mechanical Properties of All-Weld Metal

YS	TS	EL	Temp	CVN-Impact Value	Heat Treatment
MPa(lbs/in ²)	MPa(lbs/in ²)	(%)	°C(°F)	J (ft.-lbs)	
530 (77,000)	630 (91,000)	30.0	-75 (-103)	60 (44)	605 (1121°F) X 1hr. S.R

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