

S-9016.G

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E9016-G
 JIS Z3211 E5716
 EN ISO 2560-A-E50 2 B 1 2
 ABS AWS A5.5 E9016-G

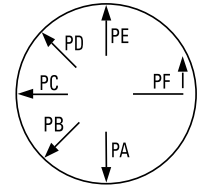
Applications

- Heavy steel fabrication
- Shipbuilding
- Offshore structure

Features

- Good bead appearance
- 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
0.06	0.52	1.09	0.016	0.010	0.56	0.23

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)
570 (82,800)	655 (95,100)	27.2	0 (32) -20 (-4)	125 (93) 78 (58)

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	180~240	250~310
V-up, OH	50~80	85~120	110~170	150~200	-

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX