

Classifications

EN ISO 2560-A:2006	: E 46 3 B 12 H10	KS D 7006	: E5316
EN ISO 2560-B:2006	: E 55 16-G A H10	JIS Z 3211	: E5516-G
AWS A5.5-06	: E8016-G		

Description

- Covering is low hydrogen type for welding of 560MPa class high tensile steel.
- Satisfactory bead appearance and slag removal.
- Excellent mechanical properties and radiographic soundness.
- Good weldability and usability.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.07	0.66	1.45	0.016	0.011	0.02	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-40°C	
AWS A5.5	min. 460	min. 550	min. 19			
EN ISO 2560-A	min. 460	530~680	min. 20	≥ 47		
Example	540	600	28	60	45	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0	6.0
Length	(mm)	350	350	400	400	450
Amp. (A)	F	60~90	90~130	140~190	180~240	250~310
	V · OH	50~80	80~120	110~170	160~200	—

Approvals

JIS, CE