

Classifications

EN ISO 2560-A:2006	: E 50 0 1Ni B 12 H10	KS D 7006	: E5816
EN ISO 2560-B:2006	: E 55 16-G A H10	JIS Z 3211	: E6216-G
AWS A5.5-06	: E9016-G		

Description

- Covering is low hydrogen type for welding of 620MPa class high tensile steel in bridges, vehicles.
- Mn-Ni-Mo type deposits weld metal.
- Satisfactory bead appearance and slag removal.
- Excellent mechanical properties and radiographic soundness.
- 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	0.58	1.04	0.018	0.011	0.64	0.03	0.29	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-20°C	
AWS A5.5	min. 530	min. 620	min. 17	≥ 47 80	50	AW
EN ISO 2560-A	min. 500	560~720	min. 18			
Example	550	650	28			

* 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 V · OH	60~90 50~80	90~130 80~110	140~190 120~170	180~230 160~200	250~300 —

Approvals

JIS, CE