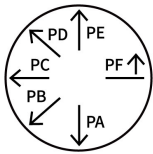


S-10016.G

Classification

AWS A5.5/ASME SFA-5.5 E10016-G
JIS Z 3211 E6916-N4CM1 U
EN ISO 18275-A E55 0 Z 1.5NiMo B 1 2
KS D7006 E7016

Welding Positions



Features

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

Polarity

AC or DC +

Application Areas

- Heavy steel fabrication
- Pressure vessels
- Power plant

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.07	0.69	1.41	0.013	0.012	1.49	0.01	0.12	0.11

Typical Mechanical Properties of All-Weld Metal

Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
710(103)	762(111)	24	0(32)	100(74)

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6(3/32)	350(14)	60-90	50-80	Standard/Vacuum - Packet 5kg (11lbs), Carton 20kg (44lbs)
3.2(1/8)	350(14)	90-130	85-120	
4.0(5/32)	400(16)	130-180	110-170	
5.0(3/16)	400(16)	180~240	150-200	
6.0(15/64)	450(18)	250-310	-	

SAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux