

Covered Electrodes

K-8016B8

For heat-resisting steel (9%Cr-1%Mo)

Classifications

EN ISO 3580-B:2008	: E 62 16-9C1M H10	KS D 7022	: DT2616
AWS A5.5-06	: E8016-B8	JIS Z 3223	: DT2616

Description

- Covering is low hydrogen type for welding of super-heater tubes of high temperature and high pressure boilers, heater tubes of oil refining equipments.
- Preheat at 250~350°C and postheat treat at 750~850°C because of high self-hardening property of the deposited weld metal.
- 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
0.08	0.74	0.98	0.020	0.013	0.03	8.48	0.90	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				20°C	0°C	
AWS A5.5	min. 460	min. 550	min. 19			
EN ISO 3580-B	min. 530	min. 620	min. 15			
Example	690	780	21	50	45	PWHT

* PWHT : 740°Cx1Hr

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	55-90	80-120	120-160	160-220	210-260
	V · OH	50-80	70-110	90-150	-	-

Approvals

CE