

Classifications

EN ISO 2560-A:2006	: E 46 6 2Ni B 12 H10	KS D 7023	: DL5016-6P2
EN ISO 2560-B:2006	: E 55 16-N5 P U H10	JIS Z 3211	: E5516-N5 P U
AWS A5.5-06	: E8016-C1		

Description

- Covering is low hydrogen type for welding of 2.5%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Excellent impact value at -60°C
- 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	0.45	0.98	0.016	0.013	2.25	0.03	0.02	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-50°C	-60°C	
AWS A5.5	min. 460	min. 550	min. 19	≥ 27		
EN ISO 2560-B	min. 460	min. 550	min. 17	≥ 47		
Example	520	600	30	140	120	AW

* PWHT : 605°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 V · OH	60~90 50~80	110~150 100~140	150~190 120~170	200~240 150~200	250~310 -

Approvals

CE