

Classifications

EN ISO 2560-A:2006	: E 46 6 3Ni B 12 H10	KS D 7023	: DL5016-6P3
EN ISO 2560-B:2006	: E 55 16-N7 P H10	JIS Z 3211	: E5516-N7 P
AWS A5.5-06	: E8016-C2		

Description

- Covering is low hydrogen type for welding of 3.5%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Excellent impact value at -75℃
- Good weldability and usability.
- Redry the electrode at 300~400℃ 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	1.10	0.014	0.011	3.46	0.04	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-60℃	-75℃	
AWS A5.5	min. 460	min. 550	min. 19		≥ 27	
EN ISO 2560-B	min. 460	500~550	min. 17		≥ 27	
Example	500	610	30	70	55	PWHT

※ PWHT : 605℃x1Hr

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	50~90 50~80	90~130 80~120	130~180 110~160	180~240 150~200	220~260 —

Approvals

CE