

K-8016B1

AWS E8016-B1

FOR HEAT-
RESISTING STEEL

Typical applications

Welding of 0.5%Cr-0.5%Mo steel used for high temperature high pressure boilers, chemical equipments and oil refining plants.(A335-P2, A213-T2).

Coating

Low hydrogen type.

Characteristics on Usage

- ① Excellent crack resistance because of low hydrogen contents.
- ② Preheat at 150~250°C and postheat treat at 620~680°C.
- ③ Redry the electrode at 350~400°C for 60 minutes prior to use.

Typical chemical composition of all-weld-metal (%)

C	Si	Mn	Cr	Mo
0.07	0.51	0.81	0.51	0.49

Typical mechanical properties of all-weld-metal

Temp.	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	PWHT
R.T	590 {60}	670 {68}	26	690°C × 1hr. S·R
450°C	500 {51}	540 {55}	23	

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.	F	50~85	90~130	130~180	190~240	250~320
	V&OH	40~80	80~120	110~160	-	-

Welding positions



Approved by