

FOR HEAT-  
RESISTING STEEL

AWS E8016-B2  
JIS DT2316  
KS DT2316

# K-8016B2

## Typical applications

Welding of 1.25%Cr-0.5%Mo steel used for super-heater tubes, steam pipes and heaters of boilers for thermoelectric power plant and equipments of oil refining industries.

Welding of piping steel, boiler and heat exchanger steel tubes, rolled steel, cast steel and forged steel.

## Coating

Low hydrogen type.

## Characteristics on Usage

- ① Preheat at 150~300°C and postheat treat at 670~730°C.
- ② 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   |
|------|------|------|------|------|
| 0.06 | 0.47 | 0.65 | 1.31 | 0.52 |

## Typical mechanical properties of all-weld-metal

| Temp. | Y · P<br>N/mm <sup>2</sup> {kgf/mm <sup>2</sup> } | T · S<br>N/mm <sup>2</sup> {kgf/mm <sup>2</sup> } | EI<br>(%) | PWHT             |
|-------|---|---|-----------|------------------|
| R.T   | 570 {58}  | 650 {66}  | 26        | 690°C × 1hr. S·R |
| 450°C | 450 {46}  | 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    | 60~90 | 80~120 | 130~180 | 180~230 | 240~300 |
|        | V&OH | 50~80 | 75~110 | 100~160 | —       | —       |

## Welding positions



Approved by