

# K-8016C1

**AWS E8016-C1**  
**JIS DL5016-6P2**  
**KS DL5016-6P2**

FOR LOWTEMPERATURE SERVICE STEEL

## Typical applications

Welding of 2.5%Ni steels and aluminium-killed steels used at low temperature, LPG tanks, etc.

## Coating

Low hydrogen type.

## Characteristics on Usage

- ① Excellent impact value at -60°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	Ni
0.07	0.45	0.98	2.25

## Typical mechanical properties of all-weld-metal

Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	Charpy V-notch J {kgf · m}(-60°C)	PWHT
520 {53}	600 {61}	30	130 {13}	620°Cx1hr. S-R

## 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	110~150	150~190	200~240	250~310
	V&OH	50~80	100~140	120~170	150~200	-

## Welding positions



Approved by