

FOR LOWTEMPERATURE SERVICE STEEL

AWS E8016-C2
JIS DL5016-6P3
KS DL5016-6P3

K-8016C2

Typical applications

Welding of 3.5%Ni steels and aluminium-killed steels used at low temperature , LPG tanks, LNG tanks, etc.

Coating

Low hydrogen type.

Characteristics on Usage

- ① Excellent impact value at -73°C
- ② Redry the electrode at 300~350°C for 60 minutes prior to use.

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

C	Si	Mn	Ni
0.07	0.45	1.10	3.46

Typical mechanical properties of all-weld-metal

Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J{kgf · m}(-73°C)	PWHT
500 {51}	610 {62}	30	70 {7}	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	50~90	90~130	130~180	180~240	220~260
	V&OH	50~80	80~120	110~160	150~200	-

Welding positions



Approved by