

FOR LOW TEMPERATURE 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 <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	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