

K-9016B3

AWS E9016-B3
JIS DT2416
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FOR HEAT-
RESISTING STEEL

Typical applications

Welding of 2.25% Cr-1%Mo steel used for super-heater tubes, and steam pipes of boilers for electric power plant and equipments for oil refining industries and high temperature synthetic chemical industries.

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

Coating

Low hydrogen type.

Characteristics on Usage

- ① Preheat at 200~350°C and postheat treat at 680~730°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
0.08	0.45	0.78	2.37	1.03

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	620 {63}	710 {72}	24	690°C × 1hr. S-R
450°C	500 {51}	550 {56}	10	

Sizes available and recommended currents (AC or DC ⊕)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp.	F	60~100	90~130	130~190	190~240
	V&OH	60~90	75~115	110~170	—

Welding positions



Approved by