

Classifications

EN 757:1997 : E 62 0 Z B 12 H10
 AWS A5.5-06 : E11016-G

KS D 7006 : E8016
 JIS Z 3211 : E7616-G

Description

- Covering is low hydrogen type for welding of 760MPa class high strength low alloy steel, yield point 690MPa of pressure vessels, penstocks and bridges.
- Satisfactory bead appearance and slag removal.
- Excellent crack resistance and radiographic soundness.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions**Typical chemical composition of all-weld metal (%)**

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.07	0.60	1.10	0.013	0.012	1.84	0.23	0.43	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-20°C	
AWS A5.5	min. 670	min. 760	min. 15	≥ 47	40	AW
EN ISO 2560-A	min. 620	690~890	min. 18			
Example	730	830	22			

* AW : As-Welded

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. (A)	F V · OH	60~90 50~80	90~130 80~110	140~190 120~170	180~230 160~200	250~300 -

Approvals

JIS, CE