

LKE-8016-B6



LINKWELD ALLOYS INC.

AWS	A5.5 E8016-B6
EN	EN1599 E CrMo5 B 1 2
JIS	Z3223 DT2516

Characteristics:

LKE-8016-B6 is a low hydrogen electrode. The weld metal contains 5%Cr-0.5%Mo. With high tensile strength, good toughness and good heat resistance can be obtained.

Applications:

It is suitable for welding of 5%Cr-0.5%Mo steel such as ASTM A387 Gr.5 for refineries, petrochemical and electric power plants including pipe (ASTM A213-T5,A335-P5),drawing steel(A387-5),forging(A182-F5),etc.

Notes on Usage:

- 1.Dry the electrodes at 350-400 °c for 60 minutes before use.
- 2.Do not exceed the range of recommended because over heat input might decrease the impact value.
- 3.Keep the arc as short as possible.
- 4.Take the back-step method at the arc starting to prevent blowholes.
- 5.Preheat the workpiece at 250-350°C and proceed PWHT.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Mo
0.070	0.65	0.3	0.02	0.008	5.5	0.55

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	PWHT
617	715	23	740°C x1hr

Welding position:



Sizes and recommended current range (AC or DC <+>)

Diameter (mm)		3.2	4.0	5.0
Length (mm)		350	450	450
Amps	F	80-130	100-160	160-210
	V&OH	70-110	80-130	-
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20