LKE-8016-B8

LINKWELD ALLOYS INC.

AWS	A5.5 E8016-B8
EN	EN1599 E CrMo9 B 1 2
JIS	Z3223 DT2616

Characteristics:

LKE-8016-B8 is a low hydrogen electrode. The weld metal contains 9%Cr-1%Mo.With high tensile strength, good toughness and good heat resistance can be obtained.

Applications:

It is suitable for welding of 9%Cr-1%Mo steel such as ASTM A387 Gr.9 for refineries, petrochemical and electric power plants including pipe (ASTM A199-T9,A335-P9),drawing steel(A387-9),forging(A182-F9),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	0.72	0.50	0.018	0.006	9.8	1.04

Typical mechanical properties of weld metal

YP N/mm²	TS N/mm²	EL %	PWHT
600	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	80-120	100-150	160-210
	V&OH	70-110	80-130	-
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20