

Characteristics:

LKE-9016-B9 is a low hydrogen electrode. The weld metal contains 9%Cr-1%Mo and some little Nb,V to improve the creep problem at prolonged high temperature. With stable arc, low spatter and easy slag removal.

Applications:

It is suitable for welding of the steel such as ASTM A213-T91, A335 P91, A387 Gr.91,A182 F91.

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	Nb	V	N
0.085	0.7	0.25	0.01	0.009	9.0	1.00	0.04	0.20	0.05

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	PWHT
655	789	20	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