



LKE-E8016-G

LINKWELD ALLOYS INC.

AWS	A5.5 E8016-G
EN	EN499 E 46 A Z B 1 2
JIS	Z3212 D5316

Characteristics:

LKE-8016-G is a low hydrogen electrode for the welding of 550 N/mm² grade high tensile steel. With good strength property of deposited weld metal, slag removal, bead appearance and excellent weldability.

Applications:

It is suitable for welding of high carbon steel, low manganese steels, ships, high pressure vessels, pressure pipe and base metal ASTM A299/302/372, 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.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.080	1.5	0.60	0.014	0.010

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -30 °C J	PWHT
480	600	30	49	620°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	90-130	130-180	180-240
	V&OH	80-120	110-160	150-200
Weight per pack(kg)		5	5	5
Weight per carton (kg)		20	20	20