

AWS	A5.5 E9016-G
EN	EN757 E 55 3 Z B T 1 2
JIS	Z 3212 D5816

## Characteristics:

LKE-9016-G is a low hydrogen electrode for the welding of 620 N/mm<sup>2</sup> grade high tensile steel. With good mechanical property and X-ray test.

## Applications:

It is suitable for welding of shipbuilding, machine fabrication, offshore structure, pressure vessel, high pressure pipe and base metals are forging cast iron, structural steel, steel pipe for heat transfer, pressure vessel, alloy steel, ASTM A202/486 Gr90/736 Gr3, etc..

## Notes on Usage:

- 1.Preheat at 80°C is sometime required according to base metal or its thickness.
- 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	Ni	Mo
0.085	1.40	0.50	0.02	0.05	0.85	0.30

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup>	TS N/mm <sup>2</sup>	EL %	IV -20 °C J	PWHT
580	650	28	118	620 °C x 1hr

## 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