

Pipeweld 8016

All positional basic electrode that offers good CVN toughness at low temperatures. Can be used up to X80.

Specifications	
Classifications	SFA/AWS A5.5 : E8016-G EN ISO 2560-A : E 50 6 Mn1Ni B 12 H5
Approvals	NAKS/HAKC : 3.2-4.0 mm

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+-
Diffusible Hydrogen	<5.0 ml/100g
Alloy Type	C, Mn, 1% Ni
Coating Type	Basic

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	560 MPa	640 MPa	27 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	115 J
As Welded	-60 °C	100 J

Typical Weld Metal Analysis %					
C	Mn	Si	Ni	Cr	Mo
0.06	1.79	0.29	0.87	0.04	0.00

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
4.0 x 350.0 mm	80-140 A	21.4 V	59 %	69 sec	0.96 kg/h