

Covered Electrodes

K-8016C4H

For low temperature service steel (560MPa)

Classifications

EN ISO 2560-A:2006	: E 46 5 Z B 12 H5	JIS Z 3211	: E5516-N3 U H5
EN ISO 2560-B:2006	: E 55 16-N3 A U H5		
AWS A5.5-06	: E8016-C4 H4		

Description

- Covering is low hydrogen, iron powder type for welding of 1.5%Ni steel and aluminium-killed steel used at low temperature, LPG tanks, etc.
- Excellent notch toughness of the deposited weld metal at low temperature.
- Good weldability and usability and very low hydrogen content. (HD ≤4ml/100g)
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	V
0.06	0.56	0.85	0.013	0.011	1.26	0.03	0.01	0.01

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-50°C	
AWS A5.5	min. 460	min. 550	min. 19	≥ 27		
EN ISO 2560-A	min. 460	530~680	min. 20	≥ 47		
Example	530	600	28	110	70	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	350	350	400	400
Amp.	F	60~90	90~140	150~190	180~230
(A)	V · OH	50~80	80~120	120~160	-

Approvals

CE