

S-9016.B3

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E9016-B3

JIS Z3223 E6216-2C1M

EN 1599 - ECrMo2 B 1 2

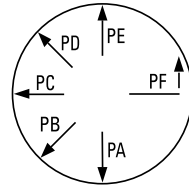
Applications

- Low alloy steel (2.25%Cr-1%Mo)
- Pressure vessels
- Power plant

Features

- Maximum service temperature at 600°C (1112°F)
- Good mechanical properties
- Good creep resistance

Welding Position



Current

AC, DC ±

Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)		√
3.2 (1/8)	350 (14)		√
4.0 (5/32)	400 (16)		√
5.0 (3/16)	400 (16)		√
6.0 (15/64)	450 (18)		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Mo
0.07	0.57	0.82	0.022	0.012	2.32	1.07

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Heat Treatment
554 (80,500)	663 (96,300)	25.6	690°C(1274°F) X 1hr. S.R

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)	6.0 (15/64)
Length mm (in)	350 (14)	350 (14)	400 (16)	400 (16)	450 (18)
F & HF	55~90	90~130	130~190	190~240	250~300
V-up, OH	50~80	80~120	120~170	-	-