

S-10016.G

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E10016-G
JIS Z3211 E6916-N4CM1 U
EN 757 - E55 0 B 1 2

SWAW

Applications

S-10016.G can be used for welding of high tensile steel, such as pressure vessels, penstock and bridges.

Characteristics on Usage

- Its workability and X-ray properties are superb in all positions.
- Good toughness of all-weld metal.
- Extremely low hydrogen contents and good crack resistibility.

Notes on Usage

- ① Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ② Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose.
- ③ Preheat at 100~150°C(212~302°F). The temperature varies in accordance with plate thickness and kind of steel.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.07	0.69	1.41	0.013	0.012	1.49	0.12

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
710 (103,130)	762 (110,680)	24.0	0 (32)	110 (81)

Approval

ABS

I Packing

Packet 5 kg (11 lbs)
Carton 5 kg (11 lbs) × 4 : 20kg(44 lbs)

Sizes Available and Recommended Currents (Amp.)

Size 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	55~90	90~130	130~180	170~240	250~310
V-up, OH	50~80	85~120	110~170	150~200	-