

## Applications

S-8016.C2 is designed for welding of 3.5%Ni steel(ASTM A203 Gr. D,E) used for pressure vessels, storage tanks.

## Characteristics on Usage

S-8016.C2 is an all position, low hydrogen type electrode for 3.5% Ni steel to be used at low temperature [-60 ~ -75°C(-75 ~ 103°F)]. Good toughness of all-weld metal at low temperature.

## Notes on Usage

- ① Dry the electrodes at 350~400 °C(662~752°F) for 60 minutes before use.
- ② Preheat at 100~150°C(212~302°F). Preheat temperature varies in accordance with the plate thickness and steel kind.
- ③ Keep the arc as short as possible.

## Welding Position



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

## Current

AC or DC +

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.50	0.90	0.011	0.006	3.20

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)	Heat Treatment
530 (77,000)	630 (91,000)	30.0	-75 (-103)	60 (44)	605 (1121°F) × 1hr. S.R

## Approval

## 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	130~190	190~240	250~300
V-up, OH	50~80	80~120	120~170	-	-