

S-9016.B3

TYPE : Basic

AWS A5.5 / ASME SFA5.5 E9016-B3
JIS Z3223 E6216-2C1M
EN 1599 - E CrMo2 B 1 2

SMAW

Applications

S-9016.B3 can be used for welding of 2.25%Cr-1%Mo steel used for super heat tubes and steam pipes of boilers for electric power plant and marine use, equipment for oil refining industries and high temperature synthetic chemical industries.

Characteristics on Usage

S-9016.B3 is a low hydrogen type electrode suitable for all position welding.

Notes on Usage

- ① Preheat at 200~350°C(392~662°F) and postheat at 680~730°C(1256~1346°F).
- ② Dry the electrodes at 350~400°C(662~752°F) for 60 minutes before use.
- ③ Keep the arc as short as possible.

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	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) × 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	-	-