

SMAW Electrodes for Chromium-Molybdenum Low Alloy Steels

GL86B8 / GL88B8

AWS A5.5M E5516(8)-B8
A5.5 E8016(8)-B8
JIS Z 3223 E6216(8)-9C1M

Product Features:

- Low hydrogen/ iron powder low hydrogen type covered electrode for low alloy heat resistant steel.
- Low hydrogen contained in weld metal to get good crack resistance.
- All deposited weld metal contains approximately 9.0%Cr-1.0 %Mo alloy elements, good for serving temperature $\leq 550^{\circ}\text{C}$.
- Good for RT examination, good mechanical properties.

Applications:

- Suitable for welding of ASTM A387Gr.9 and A335Gr.P9 steel and similar grade steels.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Cr	Mo
0.09	0.62	0.7	9.23	0.86

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Post Weld Heat Treatment (PWHT) °C×1hr
695	782	24	740

Size (mm) & recommended welding parameters (A) AC or DC+

Diameter / Length	2.6/300	3.2/350	4.0/400	5.0/450
Flat position	60~90	90~140	150~200	220~270
Vertical / overhead position	50~80	80~110	120~150	--

Note:

- 300~350°C x 1hr baking prior to use.

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