

# SMAW Electrodes for Chromium-Molybdenum Low Alloy Steels

## GL86B6

AWS A5.5M E5516-B6  
A5.5 E8016-B6

### Product Features:

- Low hydrogen/ iron powder type covered electrode for low alloy heat resistant steel.
- Very low hydrogen contained in weld metal.
- All deposited weld metal contains approximately 5.0%Cr- 0.5%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 A387Gr5 and A335Gr.P5 steel and similar grade steels.

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

| C    | Si   | Mn   | Cr   | Mo  |
|------|------|------|------|-----|
| 0.07 | 0.65 | 0.81 | 4.63 | 0.5 |

Typical mechanical properties of all weld metal

| Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% | Post Weld Heat<br>Treatment (PWHT)<br>°C×1hr |
|-------------------------------------|---------------------------------------|-----------------|----------------------------------------------|
| 527                                 | 635                                   | 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<br>position | 50~80   | 80~120  | 120~150 | ----    |

### Note:

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

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