

SMAW Electrodes for Chromium-Molybdenum Low Alloy Steels

GL86B8

AWS A5.5M E5516-B8
A5.5 E8016-B8

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 |
|------|------|------|------|------|
| 0.07 | 0.60 | 0.63 | 8.74 | 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 |
|-------------------------------------|---------------------------------------|-----------------|----------------------------------------------|
| 669 | 749 | 20 | 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 | 80~120 | 120~150 | ---- |

Note:

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

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