

# S-11016.G

Type : Basic

## Conformances

AWS A5.5/ ASME SFA5.5 E11016-G

EN 757 E62 2 Mn2NiMo B 1 2

ABS AWS A5.5 E11016-G

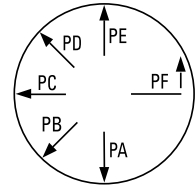
## Applications

- Heavy steel fabrication
- Pressure vessels
- Power plant

## Features

- Good crack resistance
- Good mechanical properties

## Welding Position



## Current

AC or DC +

## Redrying Conditions

300~350°C (572~662°F) X

0.5~1hr

## Diameter / Packaging

Diameter mm (in)	Length mm (in)	Standard	
		packet 5kg(11lbs)	carton 20kg(44lbs)
2.6 (3/32)	350 (14)	✓	
3.2 (1/8)	350 (14)	✓	
4.0 (5/32)	400 (16)	✓	
5.0 (3/16)	400 (16)	✓	
6.0 (15/64)	450 (18)	✓	

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.07	0.45	1.56	0.017	0.013	0.20	2.25	0.40

## 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)
760 (110,300)	790 (114,600)	24.0	-20 (-4)	130 (96)

## Typical Welding Parameters / Amp.(A)

Diameter 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	60~90	90~130	130~180	180~240	250~310
V-up, OH	50~80	85~120	110~170	150~200	-

SMW

SAW

GMW

GTAW

FCAW

Non-FERROUS

APPENDIX