



WB8016-G M.M.A. WELDING ELECTRODE

Classifications	AWS A5.5: E8016-G BS EN ISO 2560-A: E 50 6 Mn1Ni B 1 2 H5									
Product Description	All positional, thinly coated, low hydrogen electrode with excellent sub-zero impact values. The weld metal has good mechanical properties both in the as welded and stress relieved condition. Excellent welder appeal.									
Applications	Developed for welding high yield steels (450/N/mm ² min.). Used mainly for welding and repairing of high strength steels such as BS4360 55 E/F. WB8016-G exhibits excellent as-welded and post weld mechanical properties, including good CTOD values. Controlled Nickel addition ensures compliance with N.A.C.E. Used extensively on offshore fabrications/constructions.									
All-Weld Metal Composition (Weight %)	C	Mn	Si	S	P	Mo	Cr	Ni	V	Cu
min.	0.04	1.25	0.25	-	-	-	-	0.60	-	-
max.	0.08	1.50	0.65	0.020	0.025	0.05	0.05	1.00	0.01	0.05
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	*641	**578		
	Yield Stress/0.2% Proof Stress					N/mm ²	*542	**472		
	Elongation on 5D					%	*27	**31		
	Impact Energy CV @ -60°C					Joules	*63	**61		
	*As-welded									
	**Stress-relieved @ 620°C/1Hr									

Electrode Dia (mm)	1.6mm	2.0mm	2.5mm	3.2mm	4.0mm	5.0mm	6.0mm
Electrode Length (mm)	-	-	350	350/450	450	450	-
Current Range (Amps)	min.	-	55	80	110	180	-
	max.	-	85	140	180	230	-
Packaging Information							
Kg Per Packet	-	-	2	2	2	5	
Approx. Pieces Per Kg	-	-	44	21	15	10	
Vac Pac Approx. Kg Carton	-	-	20	20	20	20	
Storage and Re-Drying	Storage It is recommended that the WB range of electrodes are kept in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%. Cartons should be stacked no more than 4 high to avoid damage. Re-drying if standard packaging Re-dry @ 350°C for 2 hours and then transfer to holding oven and hold @ 100 - 200°C, or 50-100°C in heated quiver.						

Current Conditions AC (OCV70) DC+ and Welding Positions

