PipeMark 816

AWS A5.5 E8016-C3
EN ISO 2560-A-E 46 4 1Ni B 1 2 H5

Characteristics and Applications:

PipeMark 816 is an electrode for melt-through root-pass welding, or one-sided root pass welding with penetration beads. With PipeMark 816, your welding will be easier and faster. You will have confidence in the quality of your welds in any kind of pipe welding of high tensile strength steel such as S355ML.

Notes on usage:

1. Clean up the contaminations on the base metal to avoid porosity and crack.
2. Dry the electrodes at 300-350℃ for 60 minutes, and keep at 100-150℃ before using.

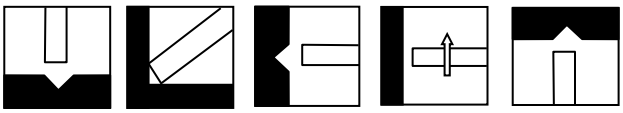
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Ni	Cr	Mo	V	Nb	Cu
AWS	≦0.12	0.40-1.25	≦0.80	≦0.03	≦0.03	0.80-1.10	≦0.15	≦0.35	≦0.05	--	--
EN ISO	--	≦1.4	--	--	--	0.6-1.2	≦0.2	≦0.2	≦0.05	≦0.05	≦0.3
Typical value	0.06	0.82	0.46	0.022	0.007	0.88	0.01	0.002	0.009	0.004	0.006

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -40°C (-40°F)
AWS	470(68)-550(80)	≧550(80)	≧24	≧27(20)
EN ISO	≧460(67)	530(77)-680(99)	≧20	≧47(35)
Typical value	530(77)	617(89)	28	68(50)

Welding position:



Sizes and recommended current range (DC＜+＞):

Diameter (mm)	3.2
Length (mm)	350
Amps	80-120

COVERED ELECTRODES

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