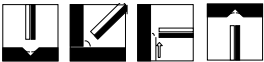


<b>RD-16B8</b>	<b>BASIC LOW HYDROGEN ELECTRODE          FOR WELDING 9Cr-1Mo STEELS          OPERATING UP TO 600°C</b>				<b>DATA SHEET          NO.          54</b>					
	SPECIFICATION	AWS A5.5	BS EN 1599	JIS Z 3223						
CLASSIFICATION	E8016-B8	E CrMo9 B	DT 2616							
PRODUCT DESCRIPTION	<p>The design emphasis of the chemically basic flux is engineered to ensure the optimum weld metal properties demanded by the specification are fully met.</p> <p>The basic flux containing the appropriate alloying elements but minimal iron powder, is extruded onto a high purity ferritic core wire and bound with a blend of silicates that ensure both coating strength and a coating resistant to subsequent moisture absorption.</p>									
WELDING FEATURES OF THE ELECTRODE	<p>The chemical nature of the flux together with its controlled coating factor allows the electrode to be used at relatively low amps. This factor together with the fairly fluid but quick freezing slag facilitate vertical up welding including controlled penetration root runs.</p> <p>Overall the arc is very stable, slag detachability is good, fillet welds are slightly convex and metal recovery is some 98% with respect to weight of the core wire.</p>									
APPLICATIONS AND MATERIALS TO BE WELDED	<p>PLATE ASTM A387 Grade 9,          TUBES/PIPES ASTM A335 Grade 9, A234 Grade WP9, A199 Grade T9, A213 Grade T9. BS 3604 Grades CFS &amp; HFS 629-470 CFS/HFS 629-590.          FORGINGS A182 Grade F9, A336 Grade F9          CAST ASTM A217 Grade C12, BS1504 Grade 629 and BS3100 Grade B6          PWHT recommended range is 725 – 755 °C and pre-heat 200-250°C.          Cool to 150°C before PWHT.</p>									
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	Fe
	MIN	0.05	-	-	-	-	8.0	-	0.85	
	MAX	0.10	1.0	0.9	0.03	0.03	10.5	0.4	1.2	
	TYPICAL	0.06	0.6	0.3	0.01	0.018	9.0	0.1	1.0	Bal.
ALL WELD METAL PROPERTIES  PWHT : 740°C For 2 hrs	PROPERTY		UNITS	MINIMUM	TYPICAL	OTHERS				
	Tensile strength		N/mm <sup>2</sup>	550	720	HV AFTER PWHT 230-240				
	0.2% Proof stress		N/mm <sup>2</sup>	460	605					
	Elongation on 4d		%	19	22					
	Reduction of Area (RA)		%	-	52					
Impact energy -20°C		J	-	85						
WELDING AMPERAGE AC or DC+	Ø (mm)	2.6	3.2	4.0	5.0					
	MIN	50	75	130	180					
	MAX	85	125	170	220					
OTHER DATA	Electrodes that have become damp should be re-dried at 150°C for 1 hour.									
RELATED PRODUCTS	Please contact our Technical Department for detail.									