

Classifications

EN ISO 2560-A:2006	: E 50 0 Z B 12	KS D 7101	: DA5816W
EN ISO 2560-B:2006	: E 55 16-G A	JIS Z 3214	: DA5816W
AWS A5.5-06	: E8016-G		

Description

- Covering is low hydrogen type for welding of 560MPa class high tensile strength weathering type structural steel for buildings, bridges and other steel structures.
- Excellent weather-proof property and crack resistance.
- Satisfactory bead appearance and slag removal.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Ni	Cr	Mo	Cu
0.07	0.65	0.75	0.016	0.011	0.62	0.53	0.01	0.50

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				0°C	-20°C	
AWS A5.5	min. 460	min. 550	min. 19			
EN ISO 2560-A	min. 500	560~720	min. 18	≥ 47		
Example	530	590	24	100	70	AW

* AW : As-Welded

Sizes available and recommended currents (AC or DC +)

Dia.	(mm)	3.2	4.0	5.0	6.0
Length	(mm)	350	400	400	450
Amp. (A)	F V · OH	90~130 70~110	150~190 120~160	180~230 130~170	240~280 —

Approvals

CE