

**CLASSIFICATIONS:****EURO CHROMET G****AWS A/SFA 5.5 E 8016-G****CHARACTERISITICS:**

A medium heavy coated, all-position, basic type of hydrogen controlled electrode for the welding of mild steel, medium high tensile and low-alloy steels and for joining cast steels to mild steel. Gives sound radiographic quality welds having excellent mechanical properties. The electrode gives good penetration, strong arc, easily detachable slag and smooth uniform weld bead.

Redry the electrodes at 300°C for 1 hour for best results.

**TYPICAL APPLICATIONS:**

- Joining class III and class IV steels.
- Repair of cast iron components (preheat necessary for large parts).
- Joining mild steel to cast iron.
- Fabrication of boilers, pressure vessels, oil tanks
- Shipbuilding.

**TYPICAL ALL WELD METAL CHEMICAL COMPOSITION:**

Element	C	Mn	Si	Ni	S	P
%	0.05-0.10	1.00-1.70	0.35-0.85	0.10max	0.03max	0.03max

**ALL WELD MECHANICAL PROPERTIES**

UTS	:	590-690N/mm <sup>2</sup>
YS	:	470-590N/mm <sup>2</sup>
Elongation(%) (l=4xd)	:	20-24
Reduction in area %	:	50-75
CVN impact value Temp 27±2 (°C)	:	120-200J

**CURRENT CONDITIONS:**

SIZE mm		2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT- Amps	AC/DC(+)	60-95	100-140	140-190	190-250