ROYAL – 8016 C2 L (E 8016-C2L)

AWS : SFA 5.5, E 8016-C2L EN ISO 2560 A E 46 6 3Ni B 32 H5

Applications

It is used for welding of nickel alloy equipments. Fabrication of pressure vessels, piping system, valves and tanks. Used for welding low temperature service for Locomotive main frames, Refineries, Pipe lines.

Characteristics on Usage

A medium heavy coated low hydrogen type electrode, the weld metal deposits 3.5%Ni in the weld metal. It is specially designed for welding fine grained steel, nickel steel and nickel alloy steel. It gives high ductility, toughness and resistance to the service temperature at minus 80° C. The electrode gives smooth arc with medium penetration and negligible spatter. It is all position electrode with radiographic quality of weld deposit. Dry the electrode at 250° C for 1 hour before using.

Welding Positions

1G 2F 3G 4G

Notes On Usage

- Dry the electrodes at 250 - 300°C
- Keep the arc as short as possible

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Ni%
0.050 Max	1.25 Max	0.60 Max	0.030 Max	0.030 Max	3.0 - 3.75

Mechanical Properties Of Weld Metal

U.T.S. (N/mm^2)	Y.S. (N/mm^2)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 75 °C (J)
560 Min	470 Min	20 % Min	27 Joules Min

Packing and Welding Current

SIZE (mm)	KG PER PACKET	KG PER CARTON	Current (Amps)	In Amps
2.50 x 350	5	20	AC / DC (+)	60 - 90
3.15 x 450	5	20		100-140
4.00 x 450	5	20		140-180
5.00 x 450	5	20		180-250