

Manual Metal Arc Electrodes

Low Alloy MMA Electrodes

Hi-Trex 8016G



AWS A/SFA 5.5-96 E8016-G
EN 499 E 50 6 Mn1Ni B 12 H5
EN ISO 2560-A E 50 6 Mn1Ni B 12 H5

Description and applications

Hi-Trex 8016G is a basic, thinly coated electrode giving a weld metal deposit with less than 1% nickel content. The weld deposit combines a minimum tensile strength of 600 N/mm² with excellent low temperature toughness down to -50°C.

Approvals

LR : 5Y 40H15

All-weld metal properties

Chemical Composition

	All weld metal %	
	Min	Max
C	0.04	0.08
Si	0.25	0.50
Mn	1.40	1.80
S		0.025
P		0.025
Cr		0.10
Ni	0.60	0.99
Mo		0.20
V		0.05
Nb		0.05
Cu		0.3

Mechanical

YS
UTS
Elongation

Charpy V impact values

As-welded

540 min	N/mm ²		
600-720	N/mm ²		
22 min	%		
at -50°C	70 min ave	J	
at -60°C	47 min ave	J	

Current range AC (min OCV 55) or DC +/- (DC preferred)

Size (mm)	2.5	3.2	4.0	5.0
Current (amps)	75-90	70-140	110-180	160-250