

Description & Applications

Electrode for welding of creep resistant steels used in the construction of pressure vessels, boilers and piping subjected to operating temperatures up to +600 °C. Welds are of X-ray quality.

Re-baking: 350 °C ± 20 °C for 2 hours.

ZULFI E8016-B2 is used for fabrication and maintenance of boilers and associated piping. Such steels as 1 1/4 Cr-1/2 Mo, and 1/2 Cr-1/2 Mo, are properly welded with ZULFI E8016-B2.

Welding current

AC, DC+

Welding Positions



Classifications

SFA/AWS A5.5 E8016-B2

All weld metal typical composition, %

C	Si	Mn	Mo	Cr
0.08	0.30	0.70	0.55	1.25

All weld metal typical mechanical properties,

Yield strength, MPa	>490
Tensile strength, MPa	>550
Elongation, %	>22

Charpy V

Test temperature, °C	+20
Impact values, J	100

Approvals

Welding parameters

Diameter, mm	Length, mm	Welding Current, A	Packet weight, kg	No. of Packet per Carton
2.5	350	70-100	2.5	8
3.2	400,450	90-140	5	4
4.0	400,450	140-190	5	4
5.0	400,450	190-250	5	4

- Available in normal pack, Vacuum pack & metal can pack.