



10016G Coated Electrode

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION;

10016G is a low alloy, low hydrogen electrode used for all position welding of 100,000 psi high tensile strength steels. This electrode produces weld deposits of good notch toughness, extremely low hydrogen content and good crack resistance. 10016G electrodes may be used with AC or DC (reverse polarity). Depending upon the thickness and hardening characteristics of the work piece, it is recommended that it be preheated at 200-300°F. 10016G is used for stress-relieved weldments in T-1, N-Xtra 100, SSS100, Jailoy-S-100, HY80 as well as wrought or cast amour plates.

TYPICAL WELDING PROCEDURES; DCEP & AC

Diameter	Amps (Flat)	Amps (Vertical & Overhead)
3/32"	55-100	50-80
1/8"	90-130	80-120
5/32"	140-200	110-160
3/16"	180-240	130-190
1/4"	250-300	NR

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

E10016-G CHEMISTRY (%) for Undiluted WELD METAL & PROPERTIES

	(AWS Requirements)	*Typical		(AWS Requirements)	*Typical
Carbon	NA	0.08	Molybdenum	0.75	0.40
Manganese	1.00 ^{(g)(m)}	1.05	Phosphorus	0.03	0.010
Silicon	0.80 ^{(g)(m)}	0.37	Sulfur	0.03	0.009
Nickel	0.80 ^{(g)(m)}	1.87	Chromium	0.30 ^{(g)(m)}	0.04

^{(g)(m)}In order to meet the alloy requirements of "G" group, the undiluted weld metal shall have the minimum of at least one of these elements.

	AWS Requirements	As Welded
Tensile Strength (psi)	100,000 min.	107,100
Yield Strength (psi)	87,000 min.	93,530
Elongation	16% min.	26.4%

AVAILABLE SIZES: TE 10016G = 3/32", 1/8", 5/32", 5/32"

SPECIFICATIONS; ANSI/AWS A5.5 E10016-G
ASME SFA 5.5 E10016-G

EAST COAST
7010-G Reames Rd
Charlotte, NC 28216
Tel (888) 522-8296
Fax (704)598-6673

GULF COAST
4755 Alpine Drive #100A
Stafford, TX 77477
Tel (877) 711-9274
Fax (281)313-6332

WEST COAST
8535 Utica Ave
Rancho Cucamonga, CA 91730
Tel (800)830-9033
Fax (909)291-4586



2-2018 DC

Warehouse Distribution Center – Portland, Oregon & Boston, Massachusetts Head Office – Puyallup, Washington

Washington Alloy Company believes that all information and data given is correct. Use this information to assist in making your own evaluations or decisions and this information should not be mistaken as an expressed or implied warranty. U.S. ALLOY CO. assumes no liability for results or damages incurred from the use of any information contained herein, in whole or in part.