BL-96 TRUSTARC™

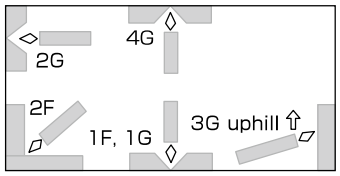
Stick electrode for Mn-Mo and Mn-Mo-Ni steel

Features: ▪ Applied for ASTM A533 Type A, B, C, D and equivalents

Classification: AWS A5.5 E9016-G

Redrying Conditions: 325~375℃x1h
Identification color: 1st Red, 2nd Green
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	17	270W, 85H, 330L
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 120H, 430L
5.0	400	5	20	86	170W, 120H, 430L
6.0	450	5	20	137	170W, 120H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.06	0.12
Si	0.50	0.60
Mn	1.23	0.90~1.70
P	0.01	0.03
S	<0.01	0.03
Ni	0.40	0.20~1.00
Mo	0.58	0.35~0.65

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	90~130	80~120
4.0	130~180	110~170
5.0	180~240	-
6.0	240~300	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	590	531min.
TS (MPa)	670	621min.
El on 4d (%)	29	17min.
IV -20℃ (J)	80	-
PWHT (℃xh)	630x1	620±15x1