BL-106 TRUSTARC™

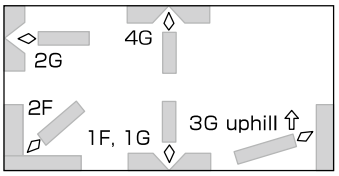
Stick electrode for Mn-Mo and Mn-Mo-Ni steel

Features: ▪ Applied for ASTM A533 Type A, B, C, D class 2 and equivalents

Classification: AWS A5.5 E10016-G

Redrying Conditions: 325~375℃x1h
Identification color: 1st White, 2nd Red
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	30	170W, 120H, 380L
4.0	400	5	20	54	170W, 120H, 430L
5.0	400	5	20	84	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.10	0.12
Si	0.53	0.60
Mn	1.41	1.00~1.60
P	0.009	0.020
S	0.005	0.020
Ni	0.76	0.60~1.00
Mo	0.50	0.40~0.65

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	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	650	600min.
TS (MPa)	730	689min.
El on 4d (%)	24	16min.
IV -20℃ (J)	80	-
PWHT (℃xh)	620x2	620±15x1