CM-2CW TRUSTARC™

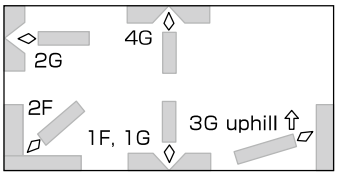
Stick electrode for low C-2.25%Cr-W-V-Nb steel

Features: ▪ Applied for ASTM A335 Gr. P23 and equivalents

Classification: AWS A5.5 E9016-G

Redrying Conditions: 325~375℃x1h
Identification color: 1st Orange, 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	57	170W, 120H, 430L
5.0	400	5	20	86	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.05	0.15
Si	0.36	0.60
Mn	0.82	0.10~1.60
P	0.007	0.020
S	0.004	0.010
Ni	0.04	0.01~1.20
Cr	2.25	1.90~2.60
Mo	0.08	0.05~0.85
Cu	0.02	0.40
W	1.45	1.00~2.00
V	0.22	0.15~0.30
Nb	0.02	0.01~0.08

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	75~115	70~110
4.0	120~160	90~150
5.0	190~240	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	570	295min.
TS (MPa)	650	510min.
El on 4d (%)	20	17min.
IV 0℃ (J)	110	-
PWHT (℃xh)	715x2	715±15x2

Approvals

ABS	MG
LR	MG
NK	MG