CM-9Cb TRUSTARC™

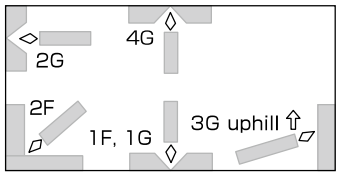
Stick electrode for 9%Cr-1%Mo-V-Nb steel

Features:
- Applied for ASTM A387 Gr.91 and equivalents
- Excellent creep rupture strength
- Good performance by AC current

Classification: AWS A5.5 E9016-G

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 85H, 330L
3.2	350	5	20	31	170W, 115H, 380L
4.0	400	5	20	55	170W, 105H, 430L
5.0	400	5	20	85	170W, 110H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.07	0.12
Si	0.39	0.60
Mn	1.51	2.00
P	0.01	0.03
S	<0.01	0.03
Ni	0.94	1.00
Cr	8.98	8.00~10.50
Mo	1.06	0.80~1.20
Nb	0.03	0.15
V	0.19	0.50

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	160~220	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	600	531min.
TS (MPa)	750	621min.
El on 4d (%)	25	17min.
IV 0℃ (J)	80	-
PWHT (℃xh)	750x5	740±15x1

Approvals

ABS	MG (AWS A5.5 E9016-G)
LR	MG
NK	MG