CM-95B91 TRUSTARC™

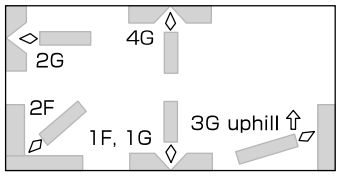
Stick electrode for 9%Cr-1%Mo-V-Nb steel

Features:
- Applied for ASTM A387 Gr.91 and equivalents
- Excellent creep rupture strength

Classification: AWS A5.5 E9015-B91

Redrying Conditions: 325~375℃x1h
Identification color: -
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.5/2.6	300	2	20	18	270W, 85H, 330L
3.2	350	5	20	31	170W, 120H, 380L
4.0	350, 400	5	20	48, 55	170W, 115H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.09	0.08~0.13
Si	0.23	0.30
Mn	0.71	1.20
P	0.01	0.01
S	<0.01	0.01
Ni	0.10	0.80
Co	0.42	-
Cr	8.4	8.0~10.5
Mo	0.99	0.85~1.20
Nb	0.06	0.02~0.10
V	0.21	0.15~0.30
Cu	0.03	-
Al	<0.01	0.04
N	0.03	0.02~0.07
Mn+Ni	0.81	1.40

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.5/2.6	55~90	50~80
3.2	75~115	70~110
4.0	120~160	90~150

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	590	531min.
TS (MPa)	730	621min.
El on 4d (%)	21	17min.
IV 20℃ (J)	70	-
PWHT (℃xh)	760x2	760±15x2