CM-96B91 TRUSTARC™

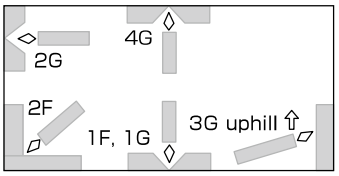
Stick electrode for 9%Cr-1%Mo-V-Nb steel

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

Classification: AWS A5.5 E9016-B91

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

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, 120H, 380L
4.0	400	5	20	55	170W, 115H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.11	0.08~0.13
Si	0.25	0.30
Mn	0.78	1.20
P	0.01	0.01
S	<0.01	0.01
Ni	0.15	0.80
Co	0.41	-
Cr	8.5	8.0~10.5
Mo	0.97	0.85~1.20
Nb	0.04	0.02~0.10
V	0.23	0.15~0.30
Cu	0.02	0.25
Al	<0.01	0.04
N	0.04	0.02~0.07
Mn+Ni	0.93	1.40

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

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	620	531min.
TS (MPa)	760	621min.
El on 4d (%)	23	17min.
IV 20℃ (J)	40	-
PWHT (℃xh)	760x2	760±15x2