CM-A76 TRUSTARC™

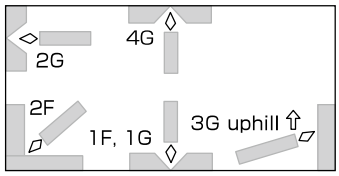
Stick electrode for 0.5%Mo steel

Features: ▪ Applied for ASTM A204 Gr. A, B, C and equivalents

Classification: AWS A5.5 E7016-A1

Redrying Conditions: 325~375℃x1h
Identification color: 1st Brown
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	170W, 120H, 330L
3.2	350	5	20	30	170W, 120H, 380L
4.0	400	5	20	55	170W, 120H, 430L
5.0	400	5	20	86	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.08	0.12
Si	0.53	0.60
Mn	0.79	0.90
P	0.01	0.03
S	<0.01	0.03
Mo	0.49	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	140~190	110~170
5.0	190~240	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	550	393min.
TS (MPa)	630	483min.
El on 4d (%)	29	22min.
IV 0℃ (J)	210	-
PWHT (℃xh)	620x1	620±15x1