CM-A96MBD TRUSTARC™

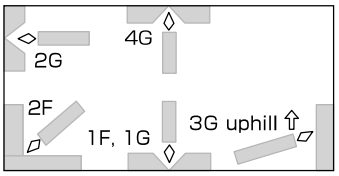
Stick electrode for 1~1.25%Cr-0.5%Mo steel

Features:
- Applied for ASTM A387 Gr.11, Gr.12 and equivalents
- Lower TS, higher IV and less sensitive to temper embrittlement

Classification: AWS A5.5 E8016-B2

Redrying Conditions: 325~375℃x1h
Identification color: 1st Black, 2nd Silver grey
Polarity: 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	30	170W, 110H, 380L
4.0	400	5	20	54	170W, 115H, 430L
5.0	400	5	20	84	170W, 110H, 430L
6.0	400	5	20	120	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.05~0.12
Si	0.47	0.60
Mn	0.79	0.90
P	0.01	0.03
S	<0.01	0.03
Cr	1.31	1.00~1.50
Mo	0.57	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	70~110	70~105
4.0	115~165	95~155
5.0	175~225	-
6.0	230~290	-

All-weld mechanical properties

	Typical		Guaranty
Temp. (℃)	RT	450	RT
0.2%YS (MPa)	520	390	462min.
TS (MPa)	620	480	552min.
El on 4d (%)	27	19	19min.
IV -20℃ (J)	170	-	-
PWHT (℃xh)	690x1	690x1	690±15x1