CM-A106 TRUSTARC™

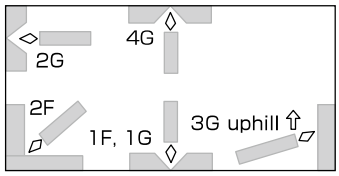
Stick electrode for 2.25%Cr-1%Mo steel

Features: ▪ Applied for ASTM A387 Gr.22 and equivalents

Classification: AWS A5.5 E9016-B3

Redrying Conditions: 325~375℃x1h
Identification color: 1st Silver, 2nd 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	270W, 85H, 330L
3.2	350	5	20	30	170W, 110H, 380L
4.0	400	5	20	55	170W, 105H, 430L
5.0	400	5	20	85	170W, 120H, 430L
6.0	400	5	20	121	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.07	0.05~0.12
Si	0.44	0.60
Mn	0.63	0.90
P	0.01	0.03
S	<0.01	0.03
Cr	2.10	2.00~2.50
Mo	1.02	0.90~1.20

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	75~115
4.0	140~190	100~160
5.0	190~240	-
6.0	240~300	-

All-weld mechanical properties

	Typical (AC)		Guaranty
Temp. (℃)	RT	450	RT
0.2%YS (MPa)	630	520	531min.
TS (MPa)	730	580	621min.
El on 4d (%)	22	17	17min.
IV 0℃ (J)	120	-	-
PWHT (℃xh)	690x1	690x1	690±15x1

Approvals

ABS	MG (AWS A5.5 E9016-B3)
LR	MG
DNV	MG (VL2Cr1Mo), H10
BV	UP (E9016-B3)
NK	MG (AWS A5.5 E9016-B3)