CM-A106HD TRUSTARC™

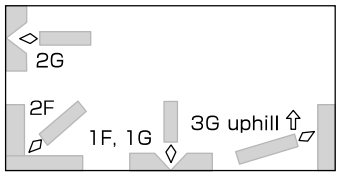
Stick electrode for 2.25%Cr-1%Mo-V steel

Features:
- Applied for ASTM A542 Type D Cl.4a and equivalents
- Excellent tensile strength at high temperatures and less sensitive to temper embrittlement

Classification: AWS A5.5 E9016-G

Redrying Conditions: 325~375℃x1h
Identification color: 1st Silver, 2nd Green
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	32	170W, 120H, 380L
4.0	400	5	20	56	170W, 110H, 430L
5.0	400	5	20	87	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.07	0.05~0.12
Si	0.24	0.20~0.50
Mn	0.87	0.50~1.30
P	<0.01	0.03
S	<0.01	0.03
Cr	2.34	2.00~2.60
Mo	1.01	0.90~1.20
V	0.30	0.20~0.40
Nb	0.018	0.010~0.040

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill
3.2	90~130	75~115
4.0	140~190	100~160
5.0	190~240	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	600	531min.
TS (MPa)	710	621min.
El on 4d (%)	21	17min.
IV -18℃ (J)	120	-
PWHT (℃xh)	705x8	705±15x8