CM-A106ND TRUSTARC™

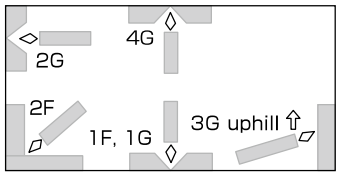
Stick electrode for 2.25%Cr-1%Mo steel

Features:
- Applied for ASTM A387 Gr.22 and equivalents
- Lower tensile strength, higher impact value and less sensitive to temper embrittlement

Classification: AWS A5.5 E9016-B3

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	350	5	20	31	170W, 120H, 380L
4.0	400	5	20	55	170W, 105H, 430L
5.0	400	5	20	86	170W, 115H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.09	0.05~0.12
Si	0.24	0.60
Mn	0.67	0.90
P	<0.01	0.03
S	<0.01	0.03
Cr	2.21	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
3.2	90~130	75~115
4.0	140~190	100~160
5.0	190~240	-

All-weld mechanical properties

	Typical		Guaranty
Temp. (℃)	RT	450	RT
0.2%YS (MPa)	500	400	531min.
TS (MPa)	640	480	621min.
El on 4d (%)	26	19	17min.
IV -40℃ (J)	150	-	-
PWHT (℃xh)	690x8	690x8	690±15x1