CM-B95 TRUSTARC™

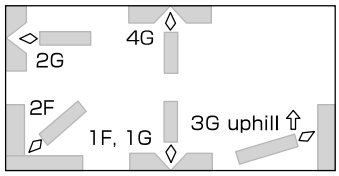
Stick electrode for 1~1.25%Cr-0.5%Mo steel

Features: ▪ Applied for ASTM A387 Gr.11, Gr.12 and equivalents

Classification: AWS A5.5 E7015-B2L

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	170W, 120H, 330L
3.2	350, 400	5	20	31, 36	170W, 120H, 380L or 430L
4.0	400	5	20	55	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.02	0.05
Si	0.93	1.00
Mn	0.74	0.90
P	0.01	0.03
S	<0.01	0.03
Cr	1.20	1.00~1.50
Mo	0.52	0.40~0.65

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	70~100	60~90
3.2	110~140	100~130
4.0	150~180	120~160

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	470	393min.
TS (MPa)	580	518min.
El on 4d (%)	29	19min.
IV 0℃ (J)	80	-
PWHT (℃xh)	690x1	690±15x1

Approvals

LR	MG