CM-B98 TRUSTARC™

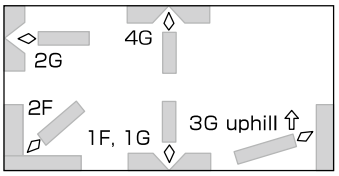
Stick electrode for 1~1.25%Cr-0.5%Mo steel

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

Classification: AWS A5.5 E8018-B2

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

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	19	170W, 120H, 330L
3.2	400	5	20	38	170W, 120H, 430L
4.0	450	5	20	69	170W, 120H, 480L
5.0	450	5	20	106	170W, 120H, 480L
6.0	450	5	20	154	170W, 120H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.07	0.05~0.12
Si	0.73	0.80
Mn	0.78	0.90
P	0.01	0.03
S	<0.01	0.03
Cr	1.31	1.00~1.50
Mo	0.54	0.40~0.65

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	65~95	60~90
3.2	90~130	80~120
4.0	135~185	110~170
5.0	190~250	-
6.0	250~320	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	590	462min.
TS (MPa)	690	552min.
El on 4d (%)	26	19min.
IV 0℃ (J)	70	-
PWHT (℃xh)	690x1	690±15x1

Approvals

LR	MG