CM-B105 TRUSTARC™

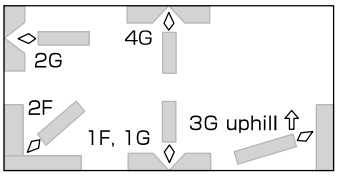
Stick electrode for 2.25%Cr-1%Mo steel

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

Classification: AWS A5.5 E8015-B3L

Redrying Conditions: 325~375℃x1h
Identification color: 1st Black, 2nd Blue
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, 120H, 430L
5.0	400	5	20	87	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.03	0.05
Si	0.90	1.00
Mn	0.79	0.90
P	0.01	0.03
S	<0.01	0.03
Cr	2.20	2.00~2.50
Mo	0.98	0.90~1.20

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
3.2	110~140	100~130
4.0	150~180	120~160
5.0	190~220	-

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	550	462min.
TS (MPa)	650	552min.
El on 4d (%)	25	17min.
IV 0℃ (J)	80	-
PWHT (℃xh)	690x1	690±15x1