CM-B108 TRUSTARC™

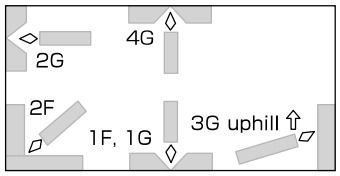
Stick electrode for 2.25%Cr-1%Mo steel

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

Classification: AWS A5.5 E9018-B3

Redrying Conditions: 325~375℃x1h
Identification color: 1st Black, 2nd Pink
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	40	170W, 120H, 430L
4.0	450	5	20	69	170W, 120H, 480L
5.0	450	5	20	108	170W, 120H, 480L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.07	0.05~0.12
Si	0.72	0.80
Mn	0.72	0.90
P	0.01	0.03
S	0.01	0.03
Cr	2.23	2.00~2.50
Mo	0.97	0.90~1.20

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	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	610	531min.
TS (MPa)	720	621min.
El on 4d (%)	23	17min.
IV 0℃ (J)	110	-
PWHT (℃xh)	690x1	690±15x1