CR-12S TRUSTARC™

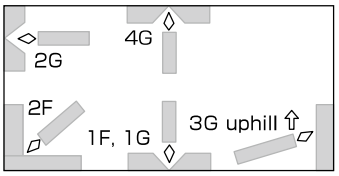
Stick electrode for 9~12%Cr-W-V-Nb steel

Features:
- Applied for ASTM A335 Gr. P92 and equivalents
- Excellent creep rupture strength

Classification: AWS A5.5 E9016-G

Redrying Conditions: 325~375℃x1h
Identification color: -
Polarity: DCEP, AC

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, 110H, 430L
5.0	400	5	20	85	170W, 120H, 430L

Composition (all-weld metal mass%)

	Typical (DCEP)	Guaranty [a]
C	0.07	0.15
Si	0.38	0.60
Mn	0.94	0.50~1.50
P	0.01	0.03
S	<0.01	0.03
Ni	0.46	1.50
Co	1.57	0.50~1.80
Cr	9.52	8.60~13.00
Mo	0.21	0.50
V	0.30	0.50
Nb	0.030	0.080
W	1.56	1.30~2.50

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	75~115	70~110
4.0	120~160	90~150
5.0	160~220	-

All-weld mechanical properties

	Typical (DCEP)	Guaranty
0.2%YS (MPa)	650	531min.
TS (MPa)	700	621min.
El on 4d (%)	22	17min.
IV 0℃ (J)	40	-
PWHT (℃xh)	740x8	750±15x8