

Shielded Metal Arc Welding

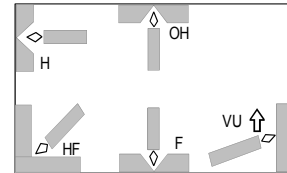
CM-A96
FAMILIARC

Low hydrogen type covered electrode for 1~1.25%Cr-0.5%Mo heat resistant steel

Classification: ASME / AWS A5.5 E8016-B2
 JIS Z3223 DT2316

Features : •Suitable for butt and fillet welding
 •Applied for ASTM A387 Gr.11, Gr.12 and equivalents

Redrying Conditions: 325~375°Cx1h

Welding Positions:

Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S	Cr	Mo
Example	0.06	0.38	0.72	0.008	0.004	1.31	0.54
Guaranty	0.05~0.12	≤0.60	≤0.90	≤0.03	≤0.03	1.00~1.50	0.40~0.65

Mechanical properties of all-weld metal as per AWS

	Temp. (°C)	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cxh)
Example	RT	570	650	26	0°C: 210	690x1
	450	460	520	21	-	690x1
Guaranty	RT	≥460	≥550	≥19	-	690±15x1

Recommended welding parameters

Dia.	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
F	55~85A	80~120A	125~175A	185~235A	240~300A
VU, OH	50~80A	75~110A	100~160A	-	-

Polarity

Example	AC
Guaranty	AC, DC-EP

Approvals

AB	LR	NV	BV	NK	Others
MG(E8016-B2)	MG(E8016-B2)	H10, NV1Cr0.5Mo	MG(E8016-B2)	MG(E8016-B2)	TÜV

Packages

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	300	2	20	17
3.2	350	5	20	29
4.0	400	5	20	53
5.0	400	5	20	82
6.0	400	5	20	122