

## Shielded Metal Arc Welding

**CM-A106**
**FAMILIARC**

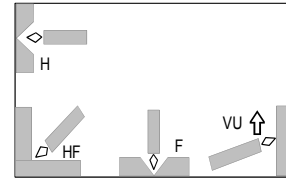
Low hydrogen type covered electrode for 2.25%Cr-1%Mo heat resistant steel

**Classification:** ASME / AWS A5.5 E9016-B3  
 JIS Z3223 DT2416

**Features :**

- Suitable for butt and fillet welding
- Applied for ASTM A387 Gr.22 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	0.07	0.34	0.61	0.006	0.004	2.10	0.96
Guaranty	0.05~0.12	≤0.60	≤0.90	≤0.03	≤0.03	2.00~2.50	0.90~1.20

**Mechanical properties of all-weld metal as per AWS**

	Temp. (°C)	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	RT	630	730	22	0°C: 120	690x1
	450	520	580	17	-	690x1
Guaranty	RT	≥530	≥620	≥17	-	690±15x1

**Recommended welding parameters**

Dia.	2.6mm	3.2mm	4.0mm	5.0mm	6.0mm
F	55~85A	90~130A	140~190A	190~240A	240~300A
VU, OH	50~80A	75~115A	100~160A	-	-

**Polarity**

Example	AC
Guaranty	AC, DC-EP

**Approvals (CMA-106)**

AB	LR	NV	BV	NK	Others
MG(E9016-B3)	MG(E9016-B3)	H10, NV2.25Cr1Mo	MG(E9016-B3)	MG(E9016-B3)	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	30
4.0	400	5	20	55
5.0	400	5	20	85
6.0	400	5	20	121