

## Shielded Metal Arc Welding

**CM-9**
**FAMILIARC**

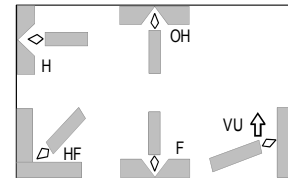
Low hydrogen type covered electrode for 9%Cr-1%Mo heat resistant steel

**Classification:** ASME / AWS A5.5 E8016-B8  
 JIS Z3223 DT2616

**Feature :**

- Suitable for butt and fillet welding
- Applied for ASTM A387 Gr.9 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	0.08	0.40	0.68	0.007	0.004	9.56	1.03
Guaranty	0.05~ 0.10	≤0.90	≤1.0	≤0.03	≤0.03	8.0~ 10.5	0.85~ 1.20

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

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cxh)
Example	510	680	26	0°C: 110	740x10
Guaranty	≥460	≥550	≥19	-	740±15x1

**Recommended welding parameters**

	2.6mm	3.2mm	4.0mm	5.0mm
F	55~85A	75~115A	120~160A	160~220A
VU, OH	50~80A	70~110A	90~150A	-

**Polarity**

Example	AC
Guaranty	AC, DC-EP

**Packages**

Dia. (mm)	Length (mm)	Weight per pack (kg)	Weight per carton (kg)	Weight per piece (g)
2.6	300	2	20	18
3.2	350	5	20	30
4.0	400	5	20	55
5.0	400	5	20	85