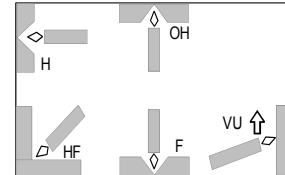


Shielded Metal Arc Welding

CM-5
FAMILIARC
Low hydrogen type covered electrode for 5%Cr - 0.5%Mo steel
Classification: ASME / AWS A5.5 E8016-B6
 JIS Z3223 DT2516

Feature : •Suitable for 5%Cr - 0.5%Mo steel
 •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	0.36	0.52	0.008	0.002	5.39	0.58
Guaranty	0.05~ 0.10	≤0.90	≤1.0	≤0.03	≤0.03	4.0~ 6.0	0.45~ 0.65

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°Cxh)
Example	400	560	33	0°C: 150	750x8
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
6.0	400	5	20	85