

Shielded Metal Arc Welding

CM-9Cb

FAMILIARC

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

Classification: ASME / AWS A5.5 E9016-G

Features : •Suitable for butt and fillet welding

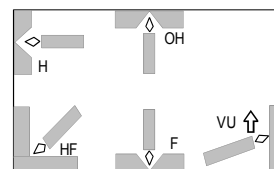
•Applicable for ASTM A387 Gr.91 and equivalents

•Excellent creep rupture strength

•Good performance by AC current

Redrying Conditions: 325~375°Cx1h

Welding Positions:



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

	C	Si	Mn	P	S	Ni	Cr	Mo	Nb	V
Example	0.06	0.31	1.51	0.006	0.003	0.94	9.11	1.06	0.03	0.18
Guaranty	≤0.12	≤0.60	≤2.00	≤0.025	≤0.025	≤1.00	8.00~ 10.50	0.80~ 1.20	≤0.15	≤0.50

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	El (%)	IV (J)	PWHT (°C×h)
Example	600	750	25	0°C: 81	750x5
Guaranty	≥530	≥620	≥17	-	740±15x1

Recommended welding parameters

Dia.	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	31
4.0	400	5	20	55
5.0	400	5	20	85