

CM-106

For welding of 2.25%Cr-1%Mo steel

AWS A5.5 E9016-B3
KS D 7022 DT2416
JIS Z3223 DT2416

Applications

Welding of 2.25%Cr-1%Mo steel used for super-heater tubes and steam pipes of boilers for electric power plant and marine use, equipments for oil refining industries and high temperature synthetic chemical industries.

Characteristics

CM-106 is a low hydrogen type electrode for all-position welding, which provides the weld metal of 2.25%Cr-1%Mo.

Notes on usage

- (1) Dry the electrodes at 325~375°C for about one hour before use.
- (2) Preheat at 200~350°C and postheat at 680~730°C.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Mo
0.08	0.80	0.42	0.013	0.006	2.30	1.06

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	PWHT
670(68)	750(76)	23	690°C × 1hr SR

Typical creep rupture strength (690°C × 1hr SR)

Test Temperature	550°C
1000hrs creep rupture strength	181N/mm ² (18.5kgf/mm ²)

Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	6.0
L (mm)	350	350	400	400	400(450)
Amp.	F	55-85	90-130	140-190	190-240
	V&OH	50-80	75-115	100-160	-

• Tip Color : Brown