

# CM-108

For welding of 2.25%Cr-1%Mo steel

AWS A5.5 E9018-B3  
KS D 7022 DT2418  
JIS Z3223 DT2418

## 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-108 is an iron powder low hydrogen type electrode for 2.25%Cr-1%Mo steel used for main steam pipes etc. Suitable for highly efficient welding of thick steam pipes and repairing of cast steel.

## 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.
- (3) Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blowholes at the arc starting.
- (4) Keep the arc as short as possible.

## Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Mo
0.06	0.76	0.48	0.015	0.008	2.26	1.07

## Typical mechanical properties of weld metal

YP N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	TS N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	EL %	PWHT
660(67)	740(75)	22	690°C×1hr SR

## 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	240-300
	V&OH	50-80	80-120	110-170	-	-

• Tip Color : Orange