

CM-93

For welding of 1.25%Cr-0.5%Mo steel

AWS A5.5 E8013-B2
KS D 7022 DT2313
JIS Z3223 DT2313

Applications

Welding of 1.25%Cr-0.5%Mo steel used for super-heater tubes and steam pipes of boilers for electric power plant and marine use, equipment for oil refining industries and high temperature synthetic chemical industries.

Characteristics

CM-93 is a low hydrogen type electrode for all-position welding, which provides the weld metal of 1.25%Cr-0.5%Mo.

Notes on usage

- (1) Pay attention not to exceed proper heat-input because excessive causes deterioration of impact values of weld metal.
- (2) Dry the electrode at 325~375°C for about one hour before use.
- (3) Preheat at 150~300°C and postheat at 670~730°C.
- (4) Keep the arc as short as possible.

Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Mo
0.08	0.51	0.31	0.015	0.009	1.28	0.51

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	PWHT
610(62)	710(72)	21.0	690 x 1hr SR

Size & recommended current range (DC±)

Dia. (mm)		2.6	3.2	4.0	5.0	6.0
L (mm)		350	350	400	400(450)	450
Amp.	F	55-85	90-130	130-180	180-240	250~300
	V&OH	50-80	80-115	110-170	-	-

• Tip Color : Orange