

CM-9

Stick electrode for 9%Cr-1%Mo steel

Features: ▪ Applied for ASTM A387 Gr.9 and equivalents

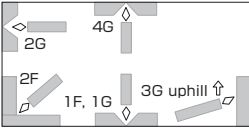
Classification: AWS A5.5 E8016-B8

Redrying Conditions: 325~375°Cx1h

Identification color: 1st Yellow, 2nd Blue

Polarity: AC, DCEP

Welding Positions:



Packaging data

φ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	300	2	20	18	270W, 85H, 330L
3.2	350	5	20	30	170W, 120H, 380L
4.0	400	5	20	55	170W, 110H, 430L
5.0	400	5	20	85	170W, 115H, 430L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty ^a
C	0.08	0.05~0.10
Si	0.46	0.90
Mn	0.7	1.0
P	0.01	0.03
S	<0.01	0.03
Ni	0.03	0.40
Cr	9.6	8.0~10.5
Mo	1.01	0.85~1.20

Note: ^a Single values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	55~85	50~80
3.2	75~115	70~110
4.0	120~160	90~150
5.0	160~220	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	510	462min.
TS (MPa)	680	552min.
El on 4d (%)	26	19min.
IV 0°C (J)	110	-
PWHT (°Cxh)	740x10	740±15x1