

CM-76

For welding of 0.5%Mo steel

AWS A5.5 E7016-A1
KS D 7022 DT1216
JIS Z3223 DT1216

Applications

Welding of 0.5%Mo steel used for high temperature and high pressure boilers, chemical and oil refining industries.

Characteristics

CM-76 is a low hydrogen type electrode for all-position welding, which provides the weld metal containing 0.5%Mo.

Notes on usage

- (1) Dry the electrodes at 325~375°C for about one hour before use.
- (2) Preheat at 100~200°C and postheat at 620~680°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	Mo
0.06	0.74	0.52	0.012	0.008	0.53

Typical mechanical properties of weld metal

Test Temp	YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	PWHT
RT	540(55)	630(64)	28	620°C x 1hr SR
450	370(38)	510(52)	22	

Size & recommended current range (AC or DC +)

Dia. (mm)		2.6	3.2	4.0	5.0	6.0
L (mm)		300	350	400	400	450
Amp.	F	55-85	90-130	140-190	190-240	250-310
	V&OH	50-80	80-120	110-170	-	-

• Tip Color : Blue-Black