

CM-78

For welding of 0.5%Mo steel

AWS A5.5 E7018-A1
KS D 7022 DT1216
JIS Z3223 DT1216
DIN EMoB26
BS EMoB

Applications

Welding of 0.5%Mo steel used for high temperature and high pressure boiler, pressure piping and tubing and other pressure vessel, chemical and oil refining industries.

Characteristics

CM-78 is an iron powder low hydrogen type electrode for all-position welding, which provides the weld metal of 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	0.75	0.50	0.015	0.008	0.50

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	PWHT
530(54)	610(62)	29	620°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	450
Amp.	F	60-80	90-130	130-180	190-240	250-310
	V&OH	55-80	80-120	110-170	-	-

• Tip Color : Red