

# CM-96

For welding of 1.25%Cr-0.5%Mo steel

AWS A5.5 E8016-B2  
KS D 7022 DT2316  
JIS Z3223 DT2316

## Applications

Welding of 1.25%Cr-0.5%Mo steel used for super heater tube, steam pipes and headers of boilers for electric power plant and equipment for oil refining industry.

## Characteristics

CM-96 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) Dry the electrodes at 325~375°C for about one hour before use.
- (2) Preheat at 150~300°C and postheat at 670~730°C.

## Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Cr	Mo
0.07	0.72	0.51	0.012	0.004	1.26	0.51

## 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
550(56)	640(65)	25	690°C×1hr SR

## Size & recommended current range (AC or DC +)

Dia. (mm)	2.6	3.2	4.0	5.0	
	L (mm)	300	350	400	400
Amp.	F	55-85	100-140	150-190	190-240
	V&OH	50-80	90-130	130-170	-

• Tip Color : Light Green