

CM-98

For welding of 1.25%Cr-0.5%Mo steel

AWS A5.5 E8018-B2
KS D 7022 DT2318
JIS Z3223 DT2318

Applications

Welding of 1.25%Cr-0.5%Mo steel used for steam pipes of boilers for electric power plant and repairing of cast steel, equipments for oil refining industries and high temperature synthetic chemical industries.

Characteristics

CM-98 is an iron powder low hydrogen type electrode. Owing to this high work efficiency, it is most suitable for welding thick steam pipes and repair welding of cast steel.

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
0.08	0.75	0.65	0.015	0.010	1.25	0.51

Typical mechanical properties of weld metal

YP N/mm ² (kgf/mm ²)	TS N/mm ² (kgf/mm ²)	EL %	PWHT
600(61)	690(70)	25	690°C × 1hr SR

Typical creep rupture strength (690°C × 1hr SR)

Test Temperature	550°C
1000hrs creep rupture strength	202N/mm ² (20.6kgf/mm ²)

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)	450
Amp.	F	65-95	90-130	135-180	190-250	250-300
	V&OH	60-90	80-120	110-170	-	-

• Tip Color : White