



## CNM (SPECIAL)

**CODIFICATION :** AWS : SFA 5.5 E12018-G

### CHARACTERISTICS AND APPLICATIONS :

CNM (Special) is a special formulated electrode to deposit a very high strength weld metal. The weld metal possesses high strength and toughness and is ideally suited for welding high strength steels.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Cr	Ni	Mo	S	P
Percent	:	0.07	1.0	0.35	1.0	2.2	0.95	0.025	0.025

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	YS (MPa)	Elongation (L = 4d)%	CVN Impact Strength at 0°C (Joules)
970	861	16.0	50

### CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	6.3x450	5x450	4x450	3.15x450	2.5x350
Dia x Length						
Current Range (Amps)	:	270-320	200-250	150-190	100-140	60-90
Qty.(Pcs./Carton)	:	25	35	55	75	125

### PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour as per our standard practice.
2. Use short arc and stringer beads.
3. Use a carefully formulated welding procedure with preheat and post weld heat treatment.