

Table A.1—Carbon and Low-alloy Steel

Base Material (See Notes 1, 2, and 4)	Carbon Steel	Carbon-molybdenum Steel	1 and 1 1/4 Cr-1/2 Mo Steel	2 1/4 Cr-1 Mo Steel	5 Cr-1/2 Mo Steel	9 Cr-1 Mo Steel	2 1/4 Nickel Steel	3 1/2 Nickel Steel	9 % Nickel Steel
carbon steel	AB (see Note 3)	AC	AD	ADE	ADEF	ADEFH	J	JK	*
carbon-molybdenum steel		C	CD	CDE	CDE	CDEFH	*	*	*
1 and 1 1/4 Cr-1/2 Mo steel			D	DE	DEF	DEFH	*	*	*
2 1/4 Cr-1 Mo steel				E	EF	EFH	*	*	*
5 Cr-1/2 Mo steel					F	FH	*	*	*
9 Cr-1 Mo steel						H (see Note 4)	*	*	*
2 1/4 nickel steel							J	JK	LM
3 1/2 nickel steel								K	LM
9 % nickel steel									LM

Key

- A ASME/AWS SFA/A 5.1, Classification E70XX low hydrogen (see Note 5).
 B ASME/AWS SFA/A 5.1, Classification E6010 for root pass (see Note 5).
 C ASME/AWS SFA/A 5.5, Classification E70XX-A1, low hydrogen.
 D ASME/AWS SFA/A 5.5, Classification E70XX-B2L (see Note 6) or E60XX-B2, low hydrogen.
 E ASME/AWS SFA/A 5.5, Classification E80XX-B3L (see Note 6) or E90XX-B3, low hydrogen.
 F ASME/AWS SFA/A 5.5, Classification E80XX-B6 or E80XX-B6L (see Note 6), low hydrogen.
 H ASME/AWS SFA/A 5.5, Classification E80XX-B8 or E80XX-B8L (see Note 6), low hydrogen.
 J ASME/AWS SFA/A 5.5, Classification E80XX-C1 or E70XX-C1L, low hydrogen.
 K ASME/AWS SFA/A 5.5, Classification E80XX-C2 or E70XX-C2L, low hydrogen.
 L ASME/AWS SFA/A 5.11, Classification ENiCrMo-3.
 M ASME/AWS SFA/A 5.11, Classification ENiCrMo-6.

* An unlikely or unsuitable combination. Consult the owner's engineer if this combination is needed.

NOTE 1 This table refers to coated electrodes. For bare wire welding (SAW, GMAW, GTAW), use equivalent electrode classifications (ASME/AWS SFA/A 5.14, SFA/A 5.17, SFA/A 5.18, SFA/A 5.20, SFA/A 5.23, SFA/A 5.26). Refer to the text for information on other processes.

NOTE 2 Higher alloy electrode specified in the table should normally be used to meet the required tensile strength or toughness after PWHT. The lower alloy electrode specified may be required in some applications to meet weld metal hardness requirements.

NOTE 4 This table does not cover modified versions of Cr-Mo alloys.

NOTE 5 See 6.1.3.

NOTE 6 PWHT can cause the strength of these filler metals to drop below minimum requirements. Care should be taken to insure adequate strength in the PWHT condition.

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