Selectarc WELDING

SELECTARC UP EB3

Creep Resistant Solid SAW Wire

Classification

AWS A5.23 : EB3R
ISO 24598-A : S2CrMo2

Material N° : 1.7305

Characteristics

Submerged arc welding wire -alloyed with Cr and Mo- for welding creep resisting steels with 2.25% Cr - 1% Mo. Resistant to high temperature up to 600°C. For piping systems, boilers, over heaters. Smooth & uniform weld bead.

Applications

Petrochemical industry, Chemical industry. Steels and Pipes for boiler and Pressure vessels

Base Materials

NFA 36-206	15CD4-05-10CD9-10
DIN 17155 & 17245	10 Cr Mo 9,10 ; 10 Cr Si Mo V7
	24 CrMo V55 ; 12 Cr Mo 9.10 GS ; 12 Cr Mo 9.10
BS	1501 Gr. 622 to 1504 Gr. 622 , BS 359 Gr. 622/640, 1503, Gr. 660, 1504 Gr.660
ASTM	A 387 Gr. D ; A 335 Gr. P22 ; A 213 Gr. T 22, T36

Typical Wire Composition (%)

C	Si	Mn	Cr	Mo	Cu	P	S	As	Sn	Sb	Fe
0.11	0.15	0.55	2.60	1.00	0.12	0.01	0.01	0.002	0.003	0.002	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS Rm (MPa)	YS Re (MPa)	%Elg A_5
PWHT	580	490	25

PWHT : After heat treatment at 690°C / 1hr

Welding Current & Instructions

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out (mm)	Flux
2.4	= +	200 - 400	28 - 32	~ 24	UP BF 10
3.2	= +	300 - 500	28 - 32	~ 32	
4.0	= +	500 - 700	29 - 33	~ 40	

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