UP EB6

Classification

AWS A5.23 : EB6 ISO 24598-A : S CrMo5

Description & Applications

Submerged arc welding wire alloyed with Chromium and Molybdenum for welding creep resisting steels with 5% Cr - 0.5% Mo. This creep resistant alloy is used for hot hydrogen service, high temperature strength at service temperatures up to 600°C.

Main applications: Oil refinery equipment.

Base material :

Creep resisting steels:	
EN	ASTM
X12CrMo5	A 182 / A 336 gr F5
G-X12CrMo5	A 199 / A 213 gr T5
	A 217 gr C5
	A 234 gr WP5
	A 335 gr P5
	A 387 gr 5

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	V	Nb	P	S	Fe
0.07	0.25	0.60	6.0	0.10	0.45	0.15	0.01	0.005	0.015	0.015	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)
490	650	20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Flux
		Current (A)	Voltage (V)	Speed (cm/min)	
SAW AC	2.4 3.2	200 - 400 300 - 500	25 - 28	45 - 55	WP380

FT-En-SF03-160601

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.