



SELECTARC UP EB2

Creep Resistant
Solid SAW Wire

Classification

AWS A 5.23 : EB2R Material N : 1.7346
 ISO 24598-A: S CrMo1

Characteristics

Submerged arc welding wire -alloyed with Cr and Mo- for welding creep resisting steels with 1%Cr - 0.5% Mo. Resistant to high temperature up to 500-550°C. For piping systems, boilers, over heaters. Smooth & uniform weld bead.

Applications

Petrochemical industry, Chemical industry.

Base materials

NFA 36-206	15D3, 18MD4.05 ,15CD2.05, 15CD4.05
DIN 17155	13CrMo4 4, 15CrMo3 , 13CrMoV4 2 ,
DIN 1681	A283 Gr. B, C, D. A570 Gr. 30, 33, 40.
ASTM	A537, A299 , A355 Gr. P11 and P12
Heat treatable steels	
NF A 35-551	18CD4 , 16CM5
NF A 35-552	25CD4
DIN 17210	25CrMo4

Typical Wire Composition (%)

C	Si	Mn	Cr	Mo	Cu	P	S	As	Sn	Sb	Fe
0.10	0.17	0.95	1.20	0.50	0.12	0.01	0.01	<0.005	<0.005	<0.005	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R _m (MPa)	YS R _{p0.2} (MPa)	% Elg A=5d
PWHT	550	470	20

PWHT : After PWHT 620°C/1h

Parameters

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out	Flux
2.4	==+	200 - 400	28 – 32	~24	UP BF 10 UP LA 01
3.2	==+	300 - 500	28 – 32	~32	
4.0	==+	500 - 700	29 – 33	~40	

Packing

25 kg Spool & also available in Drum packing.

SAW-Drum 800	SAW-Drum 1000
Outer Dia D _{1mm} = 575 +/-5	Outer Dia D _{1mm} = 575 +/-5
Inner Dia D _{1mm} =555+/-5	Inner Dia D _{1mm} =555+/-5
Inner tube/inner core D _{2mm} = 315	Inner tube/inner core D _{2mm} = 315
Hight H mm = 800	Hight H mm = 1000
Weight max. 300Kg	Weight max.400Kg

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