



# UP EB8

Creep Resistant Solid SAW Wire

## Classification

AWS A5.23 : EB8

## Characteristics

Submerged arc wire for welding creep resisting steels of similar chemical composition (known as P91) used at service temperatures up to 650°C. Deposit resisting to temperature and creep up to 620°C. Highly resistant to hot gas and overheated steam.

## Applications

For Power plants, Heat exchangers, Tubes, Steam boilers. Construction and Creep resisting steels.

### Base materials

Mat.N°	EN	ASTM
1.7386	X12CrMo9-1	A187 Gr. F9 ; A336 Gr. F9 ; A335 Gr. P9
1.7389	GX12CrMo10-1	A217 C12
1.4903	X10CrMoVNb9-1	A199 Gr. T91 ; A335 Gr. P91 ; A213 Gr. T91

## Typical WireComposition (%)

C	Si	Mn	Cr	Ni	Mo	V	Nb	P	S	Fe
0.10	0.52	0.50	8.70	0.65	1.00	0.20	0.06	0.007	0.002	Rem

## All Weld Metal Mechanical Properties (Typical)

Conditions	UTS R <sub>m</sub> (MPa)	YS R <sub>p0.2</sub> (MPa)	%Elg A <sub>c</sub>
SR 760°C/2h	750	640	20

## Welding Current & Instructions

Ø (mm)	Polarity	Current (A)	Voltage (V)	Stick out (mm)	Flux
2.4	= +	200 - 400	28 - 32	~ 24	UP WP 380
3.2	= +	300 - 500	28 - 32	~ 32	
4.0	= +	500 - 700	29 - 33	~ 40	