SUBARC EB3

SUBARC EB3 is a Copper-coated solid wire for submerged arc welding with 2.25% Cr and 1.0% Mo content to be used with basic fluxes for the welding of creep resistant steels of the ASTM A 387 Grade 22 type and similar.

CLASSIFICATIONS

AWS	A5.23-90	EB3
EN	12070	S CrMo 2
DIN	8575	UP S1 Cr Mo2

TYPICAL CHEMICAL ANALYSIS (Wire)

% Carbon	0.113	**% Sulphur**	0.012
% Manganese	0.660	**% Chromium**	2.500
% Silicon	0.205	**% Molybdenum**	0.985
% Phosphorous	0.013	**% Copper**	0.178

TYPICAL CHEMICAL ANALYSIS WELD METAL (SA 516 GR 70 PLATE)

Flux	HPF-N11X	Flux	HPF-N11X
% Carbon	0.078	**% Sulphur**	0.006
% Manganese	0.835	**% Chromium**	2.29
% Silicon	0.504	**% Molybdenum**	0.836
% Phosphorus	0.020	**% Copper**	0.111

TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL FROM ACTUAL TESTS)

Flux	MK-N AS Welded	HPF-N11X AS Welded	HPF-N11X PWHT 1hr @ 690°C
Flux/Wire Combination	F12AZ-EB3	F12A0-EB3	F11P0-EB3
Tensile Strength (MPa)	922	914	873
Yield Strength (MPa)	785	778	726
Elongation 4d %	19	23	24
Charpy Impact Value J	18J at -29°C	28J at -18°C	53J at -18°C

PACKING DATA & OPERATING PARAMETERS

Diameter (mm)	Current (A)		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	28	078-132	25
3.20	450	28	078-134	25

Recommended flux HPF-N11X. For more details on the flux used, please refer to the relevant flux data sheet

For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

AFROX