



**SUBARC EB6**

SUBARC EB6 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	EB6
EN	12070	SCrMo 5Si
DIN	8575	UP Si Cr Mo5

**TYPICAL CHEMICAL ANALYSIS (Wire)**

% Carbon	0.090	% Sulphur	0.008
% Manganese	0.490	% Chromium	5.380
% Silicon	0.420	% Molybdenum	0.560
% Phosphorous	0.005	% Copper	0.140

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

Flux	HPF-NI IX	Flux	HPF-NI IX
% Carbon	0.081	% Sulphur	0.005
% Manganese	0.710	% Chromium	4.280
% Silicon	0.570	% Molybdenum	0.370
% Phosphorus	0.017	% Copper	0.081

**TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL FROM ACTUAL TESTS)**

Flux	HPF-NI IX PWHT 1HR @ 690°C
Flux/Wire Combination	F9PZ-EB6
Tensile Strength (MPa)	681
Yield Strength (MPa)	540
Elongation 4d %	23
Charpy Impact Value J	NR

**PACKING DATA & OPERATING PARAMETERS**

Diameter (mm)	Current (DC+ / AC)		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	28	078-136	25
3.20	450	28	078-138	25

Recommended flux HPF-NI IX, for more details on the flux used please refer to the relevant flux data sheet.

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