



# UP EB3

## Classification

AWS A5.23 : EB3R

ISO 24598-A : S S CrMo2

## Description & Applications

Solid wire alloyed with Cr and Mo for submerged arc welding of creep resisting steels with 2.25% Chromium – 1.0% Molybdenum. Resistant to high service temperature up to 600°C. Nice aspect of the weld bead.

**Main applications:** Petrochemical industry, chemical industry.

**Base material:**

### Creep resisting steels:

EN	ASTM
10CrMo 9-10	A 182 gr F22
12CrMo 9-10	A 199 gr T21, T22
G-17CrMo 9-10	A 200 gr T21,T22
	A 213 gr T22
	A 217 gr WC9
	A 234 gr WP22
	A 335 gr P22
	A 387 gr 21, 22

## Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb
Min	0.08	0.05	0.40	2.25		0.90		
Max	0.15	0.25	0.70	2.8	0.3	1.10	0.15	0.01
Type	0.11	0.15	0.60	2.5	0.03	1.0	0.10	0.005
	V	P	S	As	Sn	Sb	A/T	
Min								
Max	0.03	0.010	0.010	0.005	0.005	0.005	0.50	
Type	0.01	0.008	0.005	0.003	0.002	0.002	<0.50	

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters				Flux
		Current (A)	Voltage (V)	Stick out (mm)	Speed (cm/min)	
SAW AC / = +	2.4	200 - 400	25 - 30	18	40 - 60	UP BF10
	3.2	300 - 500	28 - 32	20	40 - 60	
	4.0	500 - 700	30 - 35	22	50 - 60	

FT En-SF01-180925

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