



PRODUCT

DATA SHEET

Chrome Moly Welding Wire

Weld Process: Submerged Arc Welding Process

Alloy: EB-2 Class: EB-2

Conforms to Certification: AWS A5.23 / ASME SFA 5.23

Alloy: DMEB-2

AWS Chemical Composition Requirements

C = 0.07 - 0.15 P = 0.025 max
Mn = 0.45 - 1.00 Cr = 1.00 - 1.75
Si = 0.05 - 0.30 Mo = 0.45 - 0.65
S = 0.025 max Cu = 0.35 max

Recommended Operation of Welding Rods

Weld parameters dependent upon the wire diameter and welding flux being used.

Deposited Chemical Composition % (Typical)

C = 0.10	S = 0.008	Mo = 0.54
Mn = 0.65	P = 0.010	Cu = 0.21
Si = 0.25	Cr = 1.45	

Application

EB-2 is used for submerged arc welding of 1 ¼ chrome, ½ moly steels.

Note: Using Neutral flux

Note: Both agglomerated and fused fluxes can be used for submerged arc welding.

Deposited All Weld Metal Properties % (AW)

Tensile Strength	84,500psi
Yield Strength	71,000psi
Elongation	22%

Note: The chemical composition of the flux mainly affects the chemistry of the weld metal and consequently its corrosion resistance and mechanical properties.

Deposited Charpy-V-Notch Impact Properties %

Not Applicable