



PRODUCT DATA SHEET

Chrome Moly Welding Wire

Weld Process: Submerged Arc Welding Process

Alloy: EB-3 Class: EB-3

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

Alloy: DMEB-3

AWS Chemical Composition Requirements

C = 0.05 - 0.15 P = 0.025 max
Mn = 0.40 - 0.80 Cr = 2.25 - 3.00
Si = 0.05 - 0.30 Mo = 0.90 - 1.10
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 = 0.09 P = 0.009 Mo = 1.02
Mn = 0.69 S = 0.007 Cu = 0.21
Si = 0.22 Cr = 2.55

Application

EB-3 is used for submerged arc welding of 2 ¼ chrome, 1 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 94,500psi
Yield Strength 81,000psi
Elongation 19%

Note: The chemical composition of the flux mainly affects the chemistry of the weld metal.

Deposited Charpy-V-Notch Impact Properties %

Not Applicable