



PRODUCT

DATA SHEET

Chrome Moly Welding Wire

Weld Process: Submerged Arc Welding Process

Alloy: EB-9 Class: EB-9

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

Alloy: DMEB-9

AWS Chemical Composition Requirements

C = 0.07 - 0.13 Mo = 0.85 - 1.15
Mn = 1.25 Cu = 0.10 max
Si = 0.50 max V = 0.15 - 0.25
S = 0.010 max Nb = 0.02 - 0.10
P = 0.010 max N = 0.03 - 0.07
Cr = 8.50 - 10.50 Al = 0.04 max
Ni = 1.00 max

Deposited Chemical Composition % (Typical)

C = 0.09 P = 0.009 Cu = 0.11
Mn = 1.00 Cr = 8.75 V = 0.19
Si = 0.20 Ni = 0.75 Nb = 0.03
S = 0.009 Mo = 0.90 N = 0.04
Al = 0.01

Note: Using Neutral flux

Mechanical Properties (Nominal Values) R.T.

Tensile Strength 100,000psi
Yield Strength 85,000psi
Elongation 22%

Application

This type wire is classified by the chemical composition of deposited weld metal in combination with a specific welding flux using the submerged welding process. The weld metal properties are obtained by the use of a properly selected flux and EB9 wire and knowing if the weldment is to be heat treated or as welded condition.

Recommended Welding Parameter

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

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

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