

Chrome Moly Welding Wire

Alloy: WWEB-3  
Class: EB-3

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

Alloy: EB-3

Weld Process: Submerged Arc Welding Process

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

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	

Note: Using Neutral flux

Deposited All Weld Metal Properties % (AW)

Tensile Strength	94,500psi
Yield Strength	81,000psi
Elongation	19%

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Operation of Welding Rods

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

Application

EB-3 is used for submerged arc welding of 2 ¼ chrome, 1 moly steels.

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.

