

SUBMERGED ARC WELDING DMEB-2

Classification: EB-2

AWS A5.23 / ASME SFA 5.23

Description, Characteristics & Applications:

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

Weld parameters dependent upon the wire diameter and welding flux being used. Both agglomerated and fused fluxes can be used for submerged arc welding. The chemical composition of the flux mainly affects the chemistry of the weld metal and consequently its corrosion resistance and mechanical properties

Typical Chemical Composition (%)

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

Deposited Chemical Composition (%) (Typical)

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

Deposited All Weld Metal Properties % (AW)

Tensile Strength	Yield Strength	Elongation (%)	Hardness	Ferrite WRC (FN)	CVN Impacts (J)
					@ °C
84,500psi	71,000psi	22%	-----	-----	-----

Note: Using Neutral flux

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