

Chrome Moly Welding Wire

Alloy: WWEB-2  
Class: EB-2

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

Alloy: EB-2

Weld Process: Submerged Arc Welding Process

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

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	

Note: Using Neutral flux

Deposited All Weld Metal Properties % (AW)

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

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-2 is used for submerged arc welding of 1 ¼ chrome, ½ 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 and consequently its corrosion resistance and mechanical properties.

