**WELDWIRE COMPANY, INC.** **Technical Information**

## Chrome Moly Welding Wire

Alloy: WWEB-9
Class: EB-9

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

## Welding Data

Weld Process: Submerged Arc Welding Process

### 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.

If additional information is needed Contact Weldwire Company, Inc. 800-523-1266