Solid Wire Electrode for Submerged Arc Welding

Classification:
ISO 24598-A - **S S CrMo5**
SFA 5.23 / AWS A5.23 - **EB6**

Characteristics:
Submerged arc welding wire suited for high temperature creep resistant 5%Cr0 .5%Mo steels . The 5%Cr0 .5%Mo creep resistant alloy is used for hot hydrogen service, high temperature strength at service temperatures up to +600 °C . Typical applications are found in oil refineries .

Typical analysis and chemical composition acc. to EN ISO 24598-A and AWS A5.23:

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	Cu total
Typical analysis BA-S CrMo5	0.08	0.30	0.50	0.60	0.1	6.0	0.015	0.015	0.14
S S CrMo5 acc. to ISO 24589-A	0.03-0.10	0.20-0.50	0.40-0.75	0.50-0.80	0.3	5.5-6.5	0.020	0.020	0.3 V 0.03 Nb 0.01
EB6 acc. to AWS A5.23	0.10	0.05-0.50	1.35-0.70	0.45-0.70	0.025	4.5-6.5	-	0.025	0.35

Base Materials:

- 5%Cr0 .5%Mo creep heat-resistant steels
- X12CrMo5
- GX12CrMo5 ASTM:
- A182/A336 grade F5
- A199/A213 grade T5
- A217 grade C5
- A234 grade WP5
- A335 grade P5
- A387 grade 5
  Suitable flux: WP 380

Flux type suitability is strongly dependent on its application . In combination with the wire electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions . Further information can be obtained from the technical flux data sheets.

Diameter:
1 .6 –3 .2 mm; sizes and tolerances acc . to ISO 544 and AWS A5 .23 .

Wire electrode surface:
Copper-coated, smooth finish free from surface defects and foreign matter.

Package forms:
Coils, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.