

Solid Wire Electrode for Submerged Arc Welding

Classification:

ISO 24598-A -
SFA 5.23 / AWS A5.23 -

S S CrMo9
EB8

Characteristics:

Submerged arc welding wire for high temperature, creep resistant steel 9%Cr-1%Mo martensitic steel . Approved for service temperatures up to 600 °C . Used for heat exchangers, boiler superheater tubing, piping and pressure vessels for the oil and gas industries.

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 CrMo9	0.08	0.35	0.50	1.0	-	9.0	0.010	0.010	0.10
S S CrMo9 acc. to ISO 24589-A	0.06-0.10	0.30-0.60	0.30-0.70	0.80-1.20	1.0	8.5-10.5	0.025	0.025	0.30 V 0.15 Nb 0.01
EB8 acc. to AWS A5.23	0.10	0.05-0.50	0.30-0.65	0.80-1.20	-	8.0-10.5	0.025	0.025	0.35

Base Materials:

- 9%Cr-1%Mo creep heat-resistant martensitic steels . ASTM: A182 F9, A199 T9, A200 T9, A213 T9, A234 WP9, A335 grade 9, A336 F9, A387 grade 9 DIN: X12CrMo 9-1, X7CrMo 9-1, GS-12CrMo 10-1
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:

2,0 – 4,0 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.