



SUBARC EB2

SUBARC EB2 is a Copper-coated solid wire for submerged arc welding with 1.25% Cr and 0.5% Mo content to be used with basic fluxes for the welding of creep resistant steels of the ASTM A 387 Grade I I type and similar.

CLASSIFICATIONS (Wire)

AWS	A5.23-90	EB2
EN	12070	SCrMo I
DIN	8575	UPS2 Cr Mo I

TYPICAL CHEMICAL ANALYSIS (Wire)

% Carbon	0.110	% Sulphur	0.007
% Manganese	0.730	% Chromium	1.330
% Silicon	0.170	% Molybdenum	0.524
% Phosphorous	0.008	% Copper	0.178

TYPICAL CHEMICAL ANALYSIS WELD METAL (SA 516 GR 70 PLATE)

Flux	HPF-NI IX	Flux	HPF-NI IX
% Carbon	0.057	% Sulphur	0.004
% Manganese	0.715	% Chromium	1.100
% Silicon	0.360	% Molybdenum	0.420
% Phosphorus	0.018	% Copper	0.320

TYPICAL MECHANICAL PROPERTIES (ALL WELD METAL FROM ACTUAL TESTS)

Flux	HPF-NI IX AS Welded	HPF-NI IX PWHT 1HR @ 690°C
Flux/Wire Combination	F8A0-EB2	F8P0-EB2
Tensile Strength (MPa)	704	630
Yield Strength (MPa)	630	546
Elongation 4d %	26	27
Charpy Impact Value J	82J at -18°C	163J at -18°C

PACKING DATA & OPERATING PARAMETERS

Diameter (mm)	Current (DC+ / AC)		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	350	28	078-130	25
3.20	450	28	078-128	25
4.00	500	28	078-129	25

For more detail on the fluxes used, please refer to the relevant flux data sheet.

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