

TALARC EB2

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.23: EB2	EN ISO 24598-A: S CrMo1

ALLOY TYPE

1.25Cr-0.5Mo content to be used for the welding of creep resistant steel.

APPLICATIONS

Copper-coated solid wire for submerged arc welding with 1.25% Cr and 0.5% Mo content to be used for the welding of creep resistant steel. It is used in chemical industry and in the ammonia synthesis process, for heat exchangers, boilers, piping and pressure vessels for temperature service up to 550°C. It will also find applications in the petro-chemical industries, suitable for facing on casting and for casting repairs. To be used with basic fluxes.

TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
0.12	0.80	0.15	0.010	0.010	1.10	-	0.50	0.15

TYPICAL MECHANICAL PROPERTIES

FLUX		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)			
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)
Basic/Neutral	after PWHT	490	570	22	150	-	-	-

WELDING GUIDELINES

Preheat and interpass temperature 150 ÷ 200°C. PWHT at 690°C for an hour.

TECHNICAL INFORMATION

Welding positions: flat and flat-frontal.



WELDING PARAMETERS

Current	DC + Reverse polarity, AC		
Diameter (mm)		2.4	
Intensity (A)		350 ÷ 450	
Volts (V)		27 ÷ 30	

Diam.	25kg Coil
2.4mm	INSEB224

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