TALARC EB3

CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.23: EB3	EN ISO 24598-A: S CrMo2

ALLOY TYPE

2.25Cr-1Mo content to be used for the welding of creep resistant steel.

APPLICATIONS

Copper-coated solid wire for submerged arc welding with 2.25% Cr and 1% 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 600°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	0.60	0.15	0.010	0.010	2.50	-	1.0	0.15

TYPICAL MECHANICAL PROPERTIES

FLUX		Yield strengt	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)			
		R	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)
Basic/ Neutral	after PWHT	570	650	20	150	-	-	-

WELDING GUIDELINES

Preheat and interpass temperature 200 ÷ 250°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	INSEB324

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