Solid Wire Electrode for Submerged Arc Welding

BA-S CrMo9

Classification:

EN ISO 24598-A	– **S CrMo9**
SFA-5.23 / AWS A5.23	– **EB8**

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

Wire electrode	C	Si	Mn	Mo	Ni	Cr	P	S	V	Nb	Cu total
Typical analysis BA-S CrMo9	0.08	0.35	0.50	1.0	–	9.0	0.010	0.010	–	–	0.10
S CrMo9 acc. to ISO 24598-A	0.06–0.10	0.3–0.6	0.3–0.7	0.8–1.2	1.0	8.5–10.5	0.025	0.025	0.15	0.01	0.30
EB8 acc. to AWS A5.23	0.10	0.05–0.5	0.3–0.65	0.8–1.2	–	8.0–10.5	0.025	0.025	–	–	0.35

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.

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.

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

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.