

SAW & FLUX

Oxford Alloy® EB3

AWS EB3 • Chrome Moly



Key Features

- ❖ A 2-1/2 Cr / 1 Mo wire for submerged arc welding applications of steels with similar chemical composition.
- ❖ A preheat and interpass temperature of not less than 350°F should be maintained during welding.
- ❖ Sometimes referred to as 521.

Conformances

AWS/ASME SFA 5.23
EB3
UNS K31115

Chemical Composition - As per AWS 5.23

C	Mn	Si	Cr	Mo	P	S
0.05-0.15	0.40-0.80	0.05-0.30	2.25-3.0	0.90-1.10	0.025 max	0.025 max
Cu						
0.35 max						

Mechanical Properties

- As per typical heat with suitable flux

	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %
Typical Results - As welded	650 (95)	560 (81)	19

Typical Welding Parameters

Diameter		Process	Volt	Amps	SAW Flux
in	(mm)				
3/32	2.4	SAW	28-32	250-400	Suitable Flux
1/8	3.2	SAW	30-34	400-600	Suitable Flux

Diameters & Packaging

Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Form	Packaging (lbs)	Diameter (mm)	Form	Packaging (kgs)
3/32	SAW	60 lb Coil 1800 lb pallet	2.4	SAW	25 kg Coil 750 kg pallet
1/8	SAW	60 lb Coil 1800 lb pallet	3.2	SAW	25 kg Coil 750 kg pallet

Actual test results may vary. Refer test result disclaimer on page 160.