

SAW & FLUX

Oxford Alloy® EB6

AWS EB6 • Chrome Moly

Key Features

- ❖ Designed for submerged arc welding applications of materials of similar composition, for high temperature service conditions.
- ❖ This is an air-hardening material and as such calls for preheat and interpass temperatures of 350°F minimum during welding.
- ❖ Sometimes referred to as 502.

Conformances

AWS/ASME SFA 5.23

EB6

UNS S50280



Chemical Composition – As per AWS 5.23						
C	Mn	Si	Cr	Mo	P	S
0.10 max	0.35-0.70	0.05-0.50	4.50-6.50	0.45-0.70	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	540 (79)	420 (61)	32

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.