



Unibraze EB-2

(EB-2)

Specifications: AWS A5.23 / ASME SFA5.23 Class EB-2 UNS K11172

Product Description: Unibraze EB-2 is used for submerged arc welding of 1¼ Cr – ½ Mo steels at elevated temperatures. Careful control of preheat, interpass temperatures, and post-weld heat treatment is necessary to prevent cracking.

Typical Chemical Composition

C	0.07 – 0.15	Mn	0.45 – 1.0
Cr	1.00 – 1.75	Mo	0.45 – 0.65
Si	0.05 – 0.30	Cu	0.35 max
P	0.025 max	S	0.025 max
Others	0.50 max		

Typical Deposited Chemical Composition (using Neutral Flux)

C	0.10	Mn	0.65
Cr	1.45	Mo	0.54
Si	.25	Cu	0.21
P	0.010	S	0.008
Others	0.50		

Note: Both agglomerated and fused fluxes can be used for SAW.

The chemical composition of the flux mainly effects the chemistry of the weld metal and consequently its corrosion resistance and mechanical properties.

Typical Deposited Mechanical Properties (As welded)

Tensile Strength	84,500 psi, min
Yield Strength	71,000 psi, min
Elongation in 2"	22% min

Standard Sizes

SAW 5/64" 3/32" 1/8" X 55 lb coils