



CEWELD ER 90S-B3 Tig

TYPE Copper coated Tig welding wire for welding creep resistant ferritic steels.

ANWENDUNGEN TIG/GTAW filler metal for high temperature creep resistant 2.25%Cr1%Mo ferritic steel. These steels are used for creep resisting applications up to ~600°C. Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries.

EIGENSCHAFTEN The filler metal has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor.(X<10 ppm)for temper embrittlement resistant applications.

KLASSIFIKATION

AWS	A 5.28: ER 90S-B3
EN ISO	21952-B: W 2C1M
F-nr	6
FM	3

GEEIGNET FÜR For matching 2.5%Cr1%Mo creep resisting ferritic steels
 EN: 10CrMo9-10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9-10
 ASTM: A182 F22, A199/A200 grades T21/T22, A213 T22, A217 WC9, A234 WP22, A335 P22, A387 grades 21/22

ZULASSUNGEN CE

SCHWEISSPOSITIONEN

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Mo
	0.09	0.5	0.55	2.5	1.1

MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
					RT	-40°C	
	690°C±15°C 1h	560	650	19	100	55	HRc

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 I1



CEWELD ER 90S-B3 Tig

ER 90S-B3 TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416803

ER 90S-B3 TIG 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416827

ER 90S-B3 TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416841

ER 90S-B3 TIG 3,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663416858