
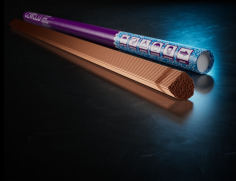


CEWELD ER 90S-B3 Tig

TYPE	Copper coated Tig welding wire for welding creep resistant ferritic steels.						
APPLICATIONS	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.						
PROPRIÉTÉS	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.						
CLASSIFICATION	AWS	A 5.28: ER 90S-B3					
	EN ISO	21952-B: W 2C1M					
	F-nr	6					
	FM	3					
CONVIENT POUR	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						
AGRÉMENTS	CE						
POSITIONS DE SOUDAGE							
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Mo		
	0.09	0.5	0.55	2.5	1.1		
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	690°C±15°C 1h	560	650	19	RT	-40°C	
					100	55	HRc
ETUVAGE	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