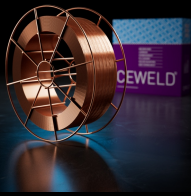




CEWELD ER 90S-B3

TYPE	Copper coated MIG welding wire for welding creep resistant ferritic steels																				
APPLICATIONS	MIG filler metal for high temperature creep resistant 2.25%Cr-1%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.																				
PROPERTIES	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	<table border="0"> <tr> <td>AWS</td> <td>A 5.28: ER 90S-B3</td> </tr> <tr> <td>EN ISO</td> <td>21952-B: G 62 M 2C1M2 (CrMo2Si)</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>3</td> </tr> </table>	AWS	A 5.28: ER 90S-B3	EN ISO	21952-B: G 62 M 2C1M2 (CrMo2Si)	F-nr	6	FM	3												
AWS	A 5.28: ER 90S-B3																				
EN ISO	21952-B: G 62 M 2C1M2 (CrMo2Si)																				
F-nr	6																				
FM	3																				
SUITABLE FOR	<p>2,25% Cr, 1% Mo</p> <p>1.7015, 1.7131, 1.7147, 1.7258, 1.7262, 1.7276, 1.7281, 1.7337, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7382, 1.7383, 1.7385, 1.7707, 1.8075</p> <p>10CrMo9.10, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7, G19CrMo9-10, 16CrMo9-3, 11CrMo9-10, 10CrMo11</p> <p>ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820</p>																				
APPROVALS	No Approvals Found																				
WELDING POSITIONS																					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> <th>Other</th> </tr> </thead> <tbody> <tr> <td>0.1</td> <td>0.5</td> <td>0.55</td> <td>0.005</td> <td>0.009</td> <td>2.45</td> <td>0.03</td> <td>0.1</td> <td>0.025</td> <td>0.03</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Other	0.1	0.5	0.55	0.005	0.009	2.45	0.03	0.1	0.025	0.03
C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Other												
0.1	0.5	0.55	0.005	0.009	2.45	0.03	0.1	0.025	0.03												
ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A5 (%)</th> <th>Impact Energy (J) ISO-V RT</th> </tr> </thead> <tbody> <tr> <td>690°C±15°C /2h</td> <td>550</td> <td>630</td> <td>18</td> <td>100</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V RT	690°C±15°C /2h	550	630	18	100										
Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V RT																	
690°C±15°C /2h	550	630	18	100																	
REDRYING TEMPERATURE	Not required																				
GAS ACCORDING EN 14175	M21																				



CEWELD ER 90S-B3

ER 90S-B3 0,9MM

Type	KG/unit	EANCode
D-200	15	8720663416742

ER 90S-B3 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663416766
D-200	15	8720663416773