



CEWELD ER 90S-B3

TYPE Copper- coated welding wire for welding creep- and hydrogen-resistant steels. P21 and P22 steels (CrMo2Si, B3Si).

APPLICATIONS CEWELD® ER 90S-B3 exhibits a bainitic microstructure in the tempered and tempered condition. It is used for processing high-temperature steels in High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc

PROPERTIES CEWELD® ER 90S-B3 has an extremely easy-to-weld wire with excellent welding properties. It typically contains 2.25 % chromium and 1.0 % molybdenum.
Weldable with Co2 and mixed gas. Suitable for heat-resistant applications at working temperatures up to 600 °C. The filler metal has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscasto Factor.(X<10 ppm)for temper embrittlement resistant applications.

CLASSIFICATION

AWS	A 5.28: ER 90S-B3
EN ISO	21952-B: G 62 M 2C1M2 (CrMo2Si)
F-nr	6
FM	3

SUITABLE FOR **2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % < Cr < 3,5 % und 0,7%<Mo < 1,2%)**
1.7015, 1.7131, 1.7147, 1.7276, 1.7281,1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7383, 1.7385, 1.7707, 1.8075
10CrMo9-10, 10CrMo11, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,

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

APPROVALS No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

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

Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	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