



CEWELD ER 90S-B3 Tig

TYPE	Tig welding wire for creep resistant A387 P21 and P22 grades.				
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.				
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	AWS	A 5.28: ER 90S-B3			
	EN ISO	21952-B: W 2C1M			
	F-nr	6			
	FM	3			
SUITABLE FOR	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				
APPROVALS	CE				
WELDING POSITIONS	PAPBPCPDPEPFPG				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Mo
	0.09	0.5	0.55	2.5	1.1
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V RT-40°C
	690°C±15°C /1h	560	650	19	10055
REDRYING TEMPERATURE	Not required				
GAS ACCORDING EN 14175	I1				



CEWELD ER 90S-B3 Tig

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

Type	KG/unit	EANCode
Tube	5	8720663416803

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

Type	KG/unit	EANCode
Tube	5	8720663416827

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

Type	KG/unit	EANCode
Tube	5	8720663416841

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

Type	KG/unit	EANCode
Tube	5	8720663416858