



# CEWELD ER 90S-B3 Tig

<b>TYPE</b>	Tig welding wire for creep resistant A387 P21 and P22 grades.					
<b>APPLICATIONS</b>	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.					
<b>PROPERTIES</b>	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.					
<b>CLASSIFICATION</b>	AWS	A 5.28: ER 90S-B3				
	EN ISO	21952-B: W 2C1M				
	F-nr	6				
	FM	3				
<b>SUITABLE FOR</b>	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					
<b>APPROVALS</b>	CE					
<b>WELDING POSITIONS</b>						
<b>TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)</b>	C	Si	Mn	Cr	Mo	
	0.09	0.5	0.55	2.5	1.1	
<b>MECHANICAL PROPERTIES</b>	Heat Treatment	$R_{P0.2}$ (MPa)	$R_m$ (MPa)	A5 (%)	Impact Energy (J) ISO-V RT      -40°C	Hardness
	690°C±15°C 1h	560	650	19	100      55	HRc
<b>REDRYING</b>	Not required					
<b>GAS ACC. EN ISO 14175</b>	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