



# CEWELD ER 90S-B3 Tig

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    |                         |          |     |
|---------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|----------------------|--------------------|-------------------------|----------|-----|
| TYPE                                              | Copper coated Tig welding wire for welding creep resistant ferritic steels.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                         |                      |                    |                         |          |     |
| TOEPASSINGEN                                      | 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.                                                                                                                                                                                                                      |                         |                      |                    |                         |          |     |
| EIGENSCHAPPEN                                     | 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.                                                                                                                                                                                                                                                                                                                                                                                          |                         |                      |                    |                         |          |     |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | A 5.28: ER 90S-B3       |                      |                    |                         |          |     |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 21952-B: W 2C1M         |                      |                    |                         |          |     |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 6                       |                      |                    |                         |          |     |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 3                       |                      |                    |                         |          |     |
| GESCHIKT VOOR                                     | <b>2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % &lt; Cr &lt; 3,5 % und 0,7%</b><br>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<br>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,<br><br>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 |                         |                      |                    |                         |          |     |
| GOEDKEURINGEN                                     | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |          |     |
| LASPOSITIES                                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                         |                      |                    |                         |          |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | Si                      | Mn                   | Cr                 | Mo                      |          |     |
|                                                   | 0.09                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 0.5                     | 0.55                 | 2.5                | 1.1                     |          |     |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V | Hardness |     |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                         |                      |                    | RT                      | 0°C      |     |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 500                     | 610                  | 23                 | 150                     | 60       | HRc |
| HERDROGEN                                         | 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 |