



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	2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % < Cr < 3,5 % und 0,7% 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						
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 _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	500	610	23	RT	0°C	
					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