

CEWELD ER 90S-B3

TYPE Copper coated MIG welding wire for welding creep resistant ferritic steels

APPLICATIONS MIG filler metal for high temperature creep resistant 2.25%Cr-1%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.

PROPRIÉTÉS 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: G 62 M 2C1M2 (CrMo2Si)
F-nr	6
FM	3

CONVIENT POUR **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

AGRÉMENTS

POSITIONS DE SOUDAGE



**ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL
D'APPORT (%)**

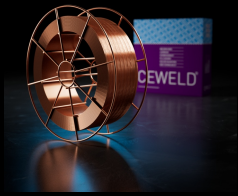
C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Other
0.1	0.5	0.55	0.005	0.009	2.45	0.03	0.1	0.025	0.03

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
690°C±15°C 2h	550	630	18	100	HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175 M21



CEWELD ER 90S-B3

ER 90S-B3 0,9MM

Packaging	KG/unit	EanCode
D-200	15	8720663416742

ER 90S-B3 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663416766
D-200	15	8720663416773