



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	PAPBPCPDPEPFPG									
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)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
	690°C±15°C 2h		550	630	18	RT			HRc	
ETUVAGE	Not required									
GAS ACC. EN ISO 14175	M21									



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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