

❖ Product Description

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| I. Copper coated low alloy solid wire | IV. Typical 2.25Cr-1Mo weld deposit |
| II. Uniform copper coating | V. Increased strength and toughness PWHT |
| III. The weld deposits are notch free with excellent mechanical strength | VI. Radiographic weld quality |

❖ Range of Application

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| I. Welding of 2.25Cr-0.5Mo and 2.25Cr-1Mo type creep resistant steels | III. Can be used in refineries, petrochemicals and fertilizers plant |
| II. Joining ASTM A 335 GrP22, A 387 Gr.22 material | IV. Suitable for 10CrSiMoV7 German steels |

❖ Classification

- AWS/SFA 5.28 ER90S- B3

❖ % Chemical Composition

Type of Wire		C	Mn	S	Si	P	Ni	Mo	Cr	Cu	Other Elements
ER90S- B3	Min	0.07	0.40	-	0.40	-	-	0.90	2.30	-	-
	Max	0.12	0.70	0.025	0.70	0.025	0.20	1.20	2.70	0.35	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa (Min)	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ 0°C
PWHT	620	540	17	-

❖ Wire Size & Welding Position

- Diameter in mm- 0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60
- Weld Position- All position

❖ Current & Gas Flow

- DCEP; 15-22lit/min

❖ Packaging

Sizes Available in mm	0.60, 0.80, 0.90, 1.00, 1.20, 1.40, 1.60								
Packing Code	A	B	C	D	E	F	G	H	I
Packing Available	SD 100	SD200	SD270	SD 270	SD300	SD300	100kg Drum Pack	250kg Drum Pack	350kg Drum Pack
Net Weight of Wire	1KG	2KG	12.5KG	15KG	12.5KG	15KG	100KG	250KG	350KG

Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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