

## ❖ Product Description

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|--|---|
| I. Low alloy steel solid filler rod copper coated    | III. It fulfils the X-factor requirements |
| II. Excellent high strength and toughness after PWHT | IV. Radiographic weld quality             |

## ❖ Range of Application

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|---|--|
| I. Suitable for welding of 2.25Cr-0.5Mo, 2.25Cr-1Mo type creep resistant steels | III. Can be used for bearings such as Cr-Mo and Cr-Mo-V which are high temperature application |
| II. Effective application in Refineries, Petrochemical and fertilizers plant    |  |

## ❖ Classification

- AWS/SFA 5.28 ER90S-B3

## ❖ Chemical Composition

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

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charpy "v" Notch Impact @ 0°C
As Welded	620	540	17	-

## ❖ Wire Sizes & Weld Position

- Diameter in mm-1.6, 2.0, 2.40, 3.20, 4.00 and 5.00.
- All position

## ❖ Current and Gas- Flow Rate

- DCEN & 8-15 lit/min

## ❖ Packaging

Sizes available in cut length of 1000mm	1.60,2.00,2.40,3.20,4.00,5.00			
Packing Code	A		B	
Packing Available	5kg PLASTIC TUBE	20KG BOX	10KG PAPER TUBE	20KG BOX
Net Weight of Wire	5	20	10	20

### Special Note: -

All the value above mentioned are typical values.

- (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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