

❖ Product Description

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| I. The wire is copper coated low alloy steel filler wire | IV. Radiographic weld quality |
| II. Uniform copper coating | V. Improved and offers long term creep properties |
| III. The wire feeding is smooth | |

❖ Range of Application

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|---|--|
| I. Suitable for welding of Cr-Mo-V-Nb steels such as P91, T91 and F91 | pipng and turbine rotors in power generating plants |
| II. Effective for welding heavy wall components such as headers, main steam | III. Can be used for material 1.4903, SA 987 Gr.91, SA 213 T91, SA 335 P91 |

❖ Classification

- AWS/SFA 5.28 ER90S-B9

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cu	Ni	Cr	Mo	V	Al	Cu	Other Elements Total
ER90S-B9	Min	0.7	-	0.15	-	-	-	-	8.00	0.85	0.15	-	-	-
	Max	0.13	1.20	0.50	0.010	0.010	0.20	0.80	10.50	1.20	0.30	0.04	0.20	0.50

❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa (Min)	YS, Mpa (Min)	% Elongation	Charphy "v" Notch Impact @ 0°C
As Welded	620	410	16	-

❖ Wire Size and 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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