



TIGFIL 90S-B3 SPL

GTAW LOW ALLOY STEEL (High Temperature)

AWS A/SFA 5.28 **ER90S-B3**

CLASSIFICATION:

EN ISO 21952-B

W 62 I1 2C1M

IS 6419

SLA-4-I-564

KEY FEATURES:

- Copper coated low alloy steel solid filler rod
- Typical 2.25 Cr-1 Mo weld deposit
- Notch free welds with excellent mechanical properties
- Superior strength and toughness after PWHT
- Meets X factor requirement
- Radiographic quality weld

TYPICAL APPLICATIONS:

- Welding of 2.25Cr-0.5Mo and 2.25Cr-1Mo type creep resistant steels
- Joining ASTM A 335 Gr.P22, A 387 Gr.22 materials
- Refineries, Petrochemicals and fertilizers plant
- Joining of P5A materials
- Cr-Mo and Cr-Mo-V bearing steels for hightemperature applications
- Suitable for 12CrMo9-10, 10CrSiMoV7 German steels

TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:


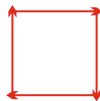
C	Mn	Si	Cr	Mo
0.1	0.6	0.5	2.5	0.95

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	PWHT: 690°C for 1 hr	700	600	20	50

Special Test: X Factor = $(10P + 5Sb + 4Sn + As)/100 < 15\text{ppm}$

PARAMETERS - PACKING DATA:

Ø x L, mm	Net Wt., Kg		
1.6 x 1000	20	 DCEN STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.