



TIGFIL 90S-B3

GTAW LOW ALLOY STEEL (High Temperature)

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

CLASSIFICATION:

EN ISO 21952-B
W 62 11 2C1M

IS 6419
SLA-4-I-561

KEY FEATURES:

- Copper coated low alloy steel solid filler wire & rod
- Uniform copper coating
- Deposit notch free welds with excellent mechanical properties
- Typical 2.25 Cr-1 Mo weld deposit
- Superior strength and toughness after PWHT
- Radiographic quality weld

APPROVALS: IBR/CE

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
0.09	0.6	0.5	2.45	0.95



MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 690°C for 1 hr	680	600	20

CREEP TEST DATA:

Condition	Temperature, °C	Stress, Mpa	Duration, Hrs	Strain% after 1000 Hrs
PWHT: 690°C for 1 Hr	550	140	1000	0.92
	600	80	1000	1.28

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.