

TIGFIL 90SB3

Classification
AWS A/SFA 5. 28 : ER 90S-B3

Approvals
TOYO ER 90S-B3
NPCIL

Identification: AWS classification embossed at one end of the wire.

Characteristics

A GTAW filler/rod suitable for welding of 2.25% Cr & 1% Mo. It deposits notch free weld deposit with excellent mechanical properties. Good X-ray quality welds.

Typical Applications

Specially developed for welding of pipes and tubes of matching composition in power plants, Refineries, Petrochemicals and Fertilizers Plant. Suitable for ASTM A 199 - 76, ASTM A 200 - 75, ASTM A 335 - Gr. P22, ASTM A 369 - 76, ASTM A 387 Gr. D, DIN 10CrMo910-G3, 10 Gr Mo 910.

Wire Chemistry, wt %

C	Mn	Si	S	P	Mo	Cr	Cu
0.07-0.12	0.40-0.70	0.40-0.70	0.025 max	0.025 max	0.90-1.20	2.30-2.70	0.35 max

Properties of weld metal with 100% Argon gas shielding **Current Condition: DC (-)**

All Weld Mechanical Properties After PWHT of 690°C for 1 hr.

UTS MPa	620-730
Yield strength MPa	540-650
Elongation % (L=4xd)	19-25
The chemistry & mechanical properties of the weld metal will vary with the type of shielding gas used.	

Packing Data

Dia (mm)	1.6	2.0	2.5
Length (mm)	1000	1000	1000
Primary Tube (Kg)	5	5	5
No. of Tubes	4	4	4
Secondary Cartons (Kg)	20	20	20

TIGFIL Wires are sealed in polyethylene bags and then packed in primary tubes.

TIGFIL Wires are also available in 5 Kg PSLW spools in 0.8, 1.0 and 1.2 mm sizes for orbital GTAW/TIG welding.



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