



CEWELD ER 90S-B3

TYPE Copper- coated welding wire for welding creep- and hydrogen-resistant steels. P21 and P22 steels (CrMo2Si, B3Si).

APPLICATIONS CEWELD® ER 90S-B3 exhibits a bainitic microstructure in the tempered and tempered condition. It is used for processing high-temperature steels in High pressure boiler steels, offshore, repair, construction, pipelines, tubing etc

PROPERTIES CEWELD® ER 90S-B3 has an extremely easy-to-weld wire with excellent welding properties. It typically contains 2.25 % chromium and 1.0 % molybdenum. Weldable with Co2 and mixed gas. Suitable for heat-resistant applications at working temperatures up to 600 °C. The filler metal has low levels of tramp elements (eg. Sn, As, Sb and P) providing a low Bruscato Factor.(X<10 ppm)for temper embrittlement resistant applications.

CLASSIFICATION

AWS	A 5.28: ER 90S-B3
EN ISO	21952-B: G 62 M 2C1M2 (CrMo2Si)
F-nr	6
FM	3

SUITABLE FOR **2,25% Cr, 1% Mo ISO 15608: ~5,2 (1,5 % < Cr < 3,5 % und 0,7%<Mo < 1,2%)**
 1.7015, 1.7131, 1.7147, 1.7276, 1.7281,1.7380, 1.7337, 1.7262, 1.7258, 1.7350, 1.7357, 1.7375, 1.7379, 1.7380, 1.7383, 1.7385, 1.7707, 1.8075
 10CrMo9-10, 10CrMo11, 12CrMo9-10, 10CrSiMoV7, 12CrSiMo8, 30CrMoV9, GS-18CrMo9.10, 15CrMoV5-10, 16CrMo4-4, 15CrMo5, 24CrMo5, 22CrMo4-4, GS-17CrMo5-5, 15Cr3, 16MnCr5, 20MnCr5, 10CrSiV7,
 ASTM: A 387 Gr. 22, A217 Grade WC9, A335 Gr. P22, A217 Gr. WC9, A182 F22, A182 T22, A1031 Gr.5015, A1031 Gr.5115, A1031 Gr.4820

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Other
0.1	0.5	0.55	0.005	0.009	2.45	0.03	0.1	0.025	0.03

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
690°C±15°C 2h	550	630	18	100	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 M21



CEWELD ER 90S-B3

ER 90S-B3 0,9MM

Packaging	KG/unit	EanCode
D-200	15	8720663416742

ER 90S-B3 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663416766
D-200	15	8720663416773