

# GETIG 90SB3

## IDENTIFICATION

Getig 90SB3, ER 90SB3

## CLASSIFICATION

AWS/SFA 5.28 ER 90S-B3

## DESCRIPTION

Copper coated 2.4% Cr / 1.0 % Mo alloyed solid wire for TIG welding creep resisting steels of similar composition, used in steam generation plant operating at temperature upto 600°C. Suitable for use in the chemical and petrochemical industries where resistance to hydrogen attack, corrosion from sulphur bearing crude oil and stress corrosion cracking in sour environments is required.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Cu	Ni	Mo	S	P
0.07 - 0.12	0.40 - 0.70	0.40 - 0.70	2.30 - 2.70	0.35 max	0.20 max	0.9 - 1.20	0.025 max	0.025 max

## MECHANICAL PROPERTIES (RANGE) PWHT (690OC + 15°C/1 HR)

TS (MPa)	YS (MPa)	EL (%) (L=4D)
630 - 720	550 - 630	18 - 25

## TYPICAL APPLICATIONS

- ASTM A 387 grade, Cast A 217 WC7
- A199, A200, A213, Grades T22, T36, T4
- A335 grade P22.

**SHIELDING GAS :** Pure Argon 99.99% 7 - 10 l/min.

**WELDING CURRENT :** DC (-)

## PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20