

GM 90S-B3

IDENTIFICATION

GM 90S-B3, ER 90SB3

CLASSIFICATION

AWS/SFA 5.28: ER 90S-B3

DESCRIPTION

Copper coated 2.4% Cr / 1.0 % Mo alloyed solid wire for MIG 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)

TS (N/mm ²)	YS (N/mm ²)	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 : Argon + 3 to 5% CO₂

WELDING CURRENT : DC (-)

PREHEAT AND INERPASS TEMP : 150 - 250°C

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5 / 15.0
1.2	12.5 / 15.0
1.6	12.5 / 15.0