

STRONG 90S-B3

CLASSIFICATION: AWS SFA 5.28 ER 90S-B3



Copper Coated Solid Wire For MIG & TIG Welding

CHARACTERISTICS

STRONG 90S-B3 is a high strength - low alloy steel wire with very low impurities for welding of high strength steels, typically suitable for welding 2.25Cr - 1Mo steel. It provides smooth flow, stable arc and spatter free welding under optimum conditions for x-ray quality welds.

APPLICATIONS

STRONG 90S-B3 is suitable for creep resistant welding of pipes & tubes of matching composition in Power plants, Refineries, Petrochemicals, Fertilizer plants, etc. where high tensile strength, corrosion resistance & good high temperature property along with heat resistance is desired from the weld metal.

TYPICAL WIRE CHEMISTRY (%)

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
0.07- 0.12	0.40- 0.70	0.40- 0.70	0.025 MAX	0.025 MAX	0.35 MAX	0.20 MAX	2.30- 2.70	0.90- 1.20	0.03 MAX

ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.28	Y.S.	U.T.S.	ELONGATION
	MPa	MPa	%
	≥540	≥620	≥17
Typical	610	700	21

PACKAGING SPECIFICATIONS - MIG

DIA SIZE 0.80MM / 1.00MM / 1.20MM / 1.60MM / 2.00MM

SPOOL WEIGHT 1KGS / 5KGS / 12.5KGS / 15KGS / 17.5KGS

DRUM WEIGHT 100KGS / 150KGS / 250KGS / 300KGS / 350KGS

PACKAGING SPECIFICATIONS - TIG

DIA SIZE 1.60MM / 2.00MM / 2.40MM / 3.15MM / 4.00MM

WEIGHT 5KGS / 20KGS