

# STRONG 90S-B91

CLASSIFICATION: AWS SFA 5.28 ER 90S-B91

Copper Coated Solid Wire For MIG & TIG Welding



## CHARACTERISTICS

STRONG 90S-B91 is copper-coated solid welding wire composing 9%Cr - 1%Mo and added with Niobium, Vanadium & Nitrogen. This wire is specifically designed to provide improved toughness and creep strength, weld fatigue life, oxidation & corrosion resistance at very high temperatures.

## APPLICATIONS

STRONG 90S-B91 gives stable arc, smooth welding performance and deposits radiographic quality welds. This wire is designed to weld materials in power plant, refineries, naphtha cracker units, etc. Typical application in steel types like I) Plate: A 387 Gr.91 (II) Pipes: A 335-P91 (III) Tubes: A 213 - T91.

## TYPICAL WIRE CHEMISTRY (%)

C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V	Nb	N
0.07-0.13	1.20 MAX	0.15-0.50	0.010 MAX	0.010 MAX	0.20 MAX	0.80 MAX	8.00-10.50	0.85-1.20	0.15-0.30	0.02-0.10	0.03-0.07

## ALL WELD MECHANICAL PROPERTIES

Required as per AWS 5.28	Y.S.	U.T.S.	ELONGATION
	MPa	MPa	%
	≥410	≥620	≥16
Typical	570	680	22

## 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