

# GETIG 90SB3

**IDENTIFICATION : AWS/SFA 5.28: ER 90S-B3**

### CHARACTERISTICS:

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 600oC. 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.

### 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 ( - )

### COMPOSITION OF THE WIRE (%)

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

### Mechanical Properties of Weld Metal PWHT (690°C/1 hr)

UTS (MPa)	YS (MPa)	ELN % (L=4D)
630-720	550-630	18-25

### RECOMMENDED CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	PACKING/BOX
1.6	1000	5 Kg
2.0	1000	5 Kg
2.4 / 2.5	1000	5 Kg
3.15 / 3.2	1000	5 Kg

**Manufactured by: GEE LIMITED**

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West)  
Thane, Maharashtra, India.  
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