MIG F68

Old reference: MIG 90SB3

Classification

ISO 21952-A G Z CrMo2Si
AWS A5.28 : ER90S-B3

Material N° : 1.7384

Description & Applications

Copper coated solid wire for GMAW -alloyed with Cr and Mo- for welding creep resisting steels used in service up to 600°C (including 2% Cr - 1% Mo castings). High resistance to H2S...

Base materials: **Steels and pipes for boiler and pressure vessels:**

NF A 36-206	:	15CD4-05 – 10CD9-10
DIN 17155 and 17245	:	10 Cr Mo 9.10 – 10 Cr Si Mo V7
		24 CrMo V55 – 12 Cr Mo 9.10 GS 12 Cr MO 9.10…
BS	:	1501 Gr 622 to 1504 Gr 622, BS 359 Gr 622/640 1503 Gr 660, 1504Gr 660
ASTM	:	A 387 GrD – A 335 GrP 22 – A 213 GrT 22, T36

Nuance Vallourec: Chromesco 3

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Cu	Ni	P	S	Fe
0.1	0.6	0.6	2.4	1.0	0.2	0.03	<0.015	<0.015	Rem.

All Weld Metal Mechanical Properties

R_e (MPa)	R_m (MPa)	A_5 (%)	KV (J)
520	650	22	+20°C 150

After PWHT 700°C/1h

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	1.0 1.2	150-170 180-250	25-28 26-28	EN 439: M21 (Ar/CO_2) 12-15 l/min

Ind.07

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