T Union GT ERB3

Low Alloyed Steel GTAW Rod/Wire

Classifications

AWS A5.28	EN ISO 21952-B	GB/T8110
ER90S-B3	W 2 C1M	ER62-B3

Characteristics and typical fields of application

- GTAW solid wire electrode for the welding of 2.25Cr-1Mo low alloy and creep resistant steels.
- Suitable for manufacturing creep resistant steels in boiler, tank, and pipeline.

Base materials

10 CrMo 9-10, 12 CrMo 9-10, 10 CrSiMoV 7, 15CrMoV 5-10, SA335Gr. P22, SA217 Gr.Wc9

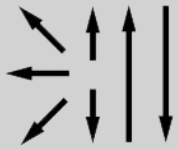
Typical analysis of all-weld metal (Wt.%)

	C	Si	Mn	P	S	Cr	Mo	Cu		
wt-%	0.09	0.55	0.62	0.009	0.006	2.35	0.95	≤0.30		

Mechanical properties of all-weld metal – typical values (min. values)

Condition	$R_{p0,2}$	R_m	A_4	K_V(J)
	MPa	MPa	%	-20 °C
690℃/1h	575 (≥ 540)	720 (≥ 620)	25 (≥ 18)	220 (≥54)

Operating data



Polarity:

DC -

Size(mm)
1.0
2.0x1000
2.4x1000

Shielding gas:
(ISO 14175)
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Approvals

CE