

PRODUCT DATA SHEET

MIG/TIG B3



MIG/TIG B3 is a low alloy solid wire, with 2,5% Cr and 1% Mo, designed for welding low alloy steels with high tensile strength and creep resistant steels. For welding ASTM A387 grade 21 and 22 and similar types employed for pipelines and pressure vessels with operating temperatures of approximately 550°C.

Classifications

AWS	A5.28	ER 90S-B3
EN	21952-A	G/W CrMo2Si (nearest)
EN	21952-B	G/W 62 M 2CIM2

Typical Chemical Analysis

% Carbon	0,08	% Sulphur	0,01
% Manganese	0,6	% Chromium	2,5
% Silicon	0,6	% Molybdenum	1,0
% Phosphorous	0,01	% Copper	0,15*

* For MIG 0,12%

Typical Mechanical Properties

	*MIG	*TIG
Tensile Strength	670 MPa	650 MPa
Yield Strength	570 MPa	570 MPa
% Elongation on 5d	20	22
Charpy V-Notch at +20°C	170 J	230 J

* After PWHT of 1 hour at 690°C

Packing Data MIG (DC+)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,0	230	25	15,0	W078310
1,2	280	26	15,0	W078312
1,6	300	26	15,0	W078314

TIG (DC-)

Diameter (mm)	Current		Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)		
1,6	100	12	5,0	W078304
2,0	100	12	5,0	W078306
2,4	100	12	5,0	W078308

Suggested shielding gas: Argoshield® 5 (MIG), Argon (TIG)

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