Key Facts

- Low alloy **Chrome-Moly 2** Gas Tungsten Arc Welding (GTAW) rod for welding of matching Chrome-Moly steels
- Low alloyed with a nominal 2-¼% Chromium and 1% Molybdenum addition to enable welding of selected low alloy, medium tensile strength steels and creep resistant steels
- Suitable for dissimilar welding of Chrome-Moly steels to Carbon Steels
- Supplied in a re-sealable heavy-duty cardboard tube

Description

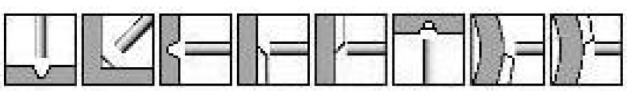
Low alloy copper-coated TIG filler rod with 2.25% Cr and 1% Mo content to be used for the welding of creep resistant steels. Also suitable for the welding of steels with 1.5-2% Cr and 1% Mo content.

Classification, Approvals & Conformances

AWS A5.18: ER90S-B3
AS/NZS 1167.2: RB3
ISO 21952-B: W 2C1M
TUV: CERT No: 11378.0006.10 to EN ISO 21952-B: W 2C1M

Welding Positions

All positional, including vertical down.



Markings & Identification

End stamped with AWS Class: ER90S-B3

Recommended Shielding Gas

Welding Grade Argon 99.95%
AS 4882-2003: SG-A ISO-14175-97: I1

Applications

Used in the chemical and ammonia synthesis process industries, for welding high temperature heat exchangers, boilers, piping and pressure vessels with service temperatures up to 600°C. **INETIG B3** also finds applications in the petro-chemical industries and is suitable for facing or build up on castings and casting repairs.

Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Si - Silicon	P - Phosphorus
0.080%	0.06%	0.60%	0.010%
S - Sulphur	**Cr - Chromium**	**Mo - Molybdenum**	**Cu – Copper**
0.010%	2.50%	1.00%	0.15%
Fe - Iron			
Remainder			

Typical All Weld Metal Mechanical Properties

Yield Strength:	570 MPa
Tensile Strength:	650 MPa
Elongation (5xD):	22%
Typical Diffusible Hydrogen Content:	≤ 3ml/100g of deposited weld metal
Impact Strength Charpy-V	230J @ +20°C

Packaging & Ordering Information

Size	Pack	Current Type and Range		Part Number
1.6mm	5kg	DC-	40-120	300143
2.4mm	5kg	DC-	60-190	300142

To ensure finished weld joints made with **INETIG B3** rods meet their mechanical properties we recommend that preheat and interpass temperature of **200°C** be maintained and Post Weld Heat Treatment (PWHT) should be at **690°C** for one hour. Temperature of **150°C** be maintained and Post Weld Heat Treatment (PWHT) should be at **620°C** for one hour.