



ER 90S-B3 (A33)

Low Alloy WIRE/GTAW



Standards

EN/ISO-Standard - 21952-B
EN/ISO-Classification - 2C1M

AWS-Standard - A5.28
AWS-Classification - ER 90S-B3

Features and Applications

- Low alloy copper coated wire with 2.25% Cr and 1% Mo content used for the welding of heat-resistant steels.
- Produces quality welds on pressure piping or boiler work.
- Designed to sustain elevated temperatures within demanding work environments.
- Recommended working temperatures of up to 600°C.
- Typical applications include pressure piping in steam power generating plants, boiler and heat exchanger tubes, chemical and petrochemical processing equipment etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



Approvals

CE, UKCA

Typical Base Materials

10CrMo9-10, GS 17CrMoV5 11, 10CrSiMoV7, 12CrSiMo8, GS12CrMo9 10, 10CrSiMoV7, 10Cr V63, 12CrSiMo8*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

Polarity

DC (-)

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % ^a	Cr %	Ni %	Mo %	Al %	V %	Fx ppm
0.08	0.50	0.60	<0.012	<0.015	<0.25	2.40	<0.20	1.00	<0.020	<0.010	<15

^a (includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
3010300367	1.60	1000	5	Cardboard Tube
3010300369	2.40	1000	5	Cardboard Tube
3010300370	3.20	1000	5	Cardboard Tube

Mechanical Properties (Typical)

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
640	540	22	90	-10°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.