

KC-90SB3

For 2.25%Cr-1%Mo heat-resistant steel

Classifications

EN ISO 21952-B:2007	: G 62 2C1M
AWS A5.28-05	: ER90S-B3
KS D 7120	: YG2CM-G
JIS Z 3317	: G 62-2C1M

Description

- For butt and fillet welding of power stations, heat exchanger and oil refineries such as 2.25%Cr-1%Mo heat-resistant steel
- Excellent property of heat-resistant due to alloying Cr and Mo
- Superior tensile strength and impact values after PWHT
- Beautiful weld appearance due to low spatter with mixture gas

Typical chemical composition of wire (%)

C	Si	Mn	P	S	Cr	Mo
0.09	0.47	0.66	0.010	0.014	2.31	1.00

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 20°C	Remarks
AWS A5.28	min. 540	min. 620	min. 17		PWHT, Ar+2% O ₂
EN ISO 21952-B	min. 540	min. 620	min. 15		PWHT
Example	570	660	24	80(@-20°C)	PWHT, Ar+2% O ₂

* PWHT : 690°Cx1Hr

Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	120 ~ 350	150 ~ 400
	Vertical (PF/3G)	80 ~ 180	100 ~ 250
	Overhead (PE/4G)	80 ~ 180	100 ~ 250

Polarity and Shielding gas

- DCEP (DC+)
- Ar+2% O₂ (15~25ℓ/min.)