

Copper coated low alloy wire 2.25% Cr and 1% Mo, used for steel which are resistant to hot creep. Recommended for petrochemical installations, on fusion or repairs. Use with a Ar+O2 gas protection.

■ Classification

AWS 5.28 : ER 90S-B3
EN ISO 2195L-B : Cr 62 M22 2 C1 M

■ Applications

- Chemical industry,
- Boilers,
- Pipework,
- Reception unit with temperature up to 600°C,
- Heat exchanger.

■ Benefits

- High resistance.
- Welding in all positions.

■ Polarity

DC +

■ Chemical properties

C %	Si %	Mn %	Mo %	Cr %	S %	P %	Cu %
0.08	0.60	0.60	1.00	2.50	0.010	0.01	0.12

■ Mechanical properties

Re	Rm	A 5 d	KV 20°C
560 Mpa	650 Mpa	> 20 %	170 J


■ Recommendations

Ø wire (mm)	0.8
voltage (V)	17 ▶ 20
current (A)	80 ▶ 180

Gas protection complies with EN ISO 14175
100% CO₂ (C1) or Argon / CO₂ (M20, M21, M31) :
12-16 l/min.



Packaging

weight (kg)	Wire reel type		Wire diameter (mm)			
			Ø 0.6	Ø 0.8	Ø 1.0	Ø 1.2
15	S300	—	—	086258	—	—