



## MODI TIG 90S-B3

### Copper Coated Low Alloy Steel TIG Wire

**CLASSIFICATION** : AWS/A 5.28 : ER 90S-B3

**CHARACTERISTICS & APPLICATIONS** : Copper coated steel TIG welding wire alloyed with nominally 2.5% Chromium (Cr) and 1.0% Molybdenum (Mo). It is recommended for the TIG welding of 2 1/4Cr-1Mo and Cr-Mo-V steel pipes, plates and castings used at elevated service temp (upto 600°C) in the power and petrochemical industries etc. It is also suitable for the dissimilar TIG welding of Cr-Mo steel to carbon steel and for TIG welding heat treatable steels and case hardenable steels upto 3% chromium content.

**CHEMICAL ANALYSIS OF WIRE (%)** :

	C	Mn	Si	Cr	Mo
	0.07-0.12	0.40-0.70	0.40-0.70	2.30-2.70	0.90-1.20

Ni	S	P
0.20 max	0.025 max	0.025 max

**MECHANICAL PROPERTIES OF ALL WELD DEPOSIT USING WELDING GRADE ARGON**

	Yield Strength (N/mm <sup>2</sup> )	Ultimate Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)
	540 min	620 min	17

**PACKING SPECIFICATION :**

Wire Size(mm)	1.6x1000	2.0x1000	2.4x1000	3.15x1000
Pack Weight/Tube (Kg)	5.25	5.25	5.25	5.25
Weight/Box	21.0	21.0	21.0	21.0



**MODI ARC ELECTRODES CO.**

Modinagar - 201 204 (U.P.)

Fax : 01232 - 242147

Phone : (01232) 325700, 325925, 243912

E-mail : modiarc@ndb.vsnl.net.in

Web Site : www.modielectrodes.com