

# TALARC B3

## CLASSIFICATION

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.28: ER90S-B3	EN ISO 21952-B: G 2C1M

## ALLOY TYPE

2.25Cr-1Mo content to be used for the welding of creep resistant steel.

## APPLICATIONS

Low alloy copper-coated solid wire with 2.25% Cr and 1% Mo content to be used for the welding of creep resistant steel. Chemical composition of wire conforming to AWS specification. It is used in chemical industry and in the ammonia synthesis process, for heat exchangers, boilers, piping and pressure vessels for temperature service up to about 600°C. It will also find applications in the petro-chemical industries, suitable for facing on casting and for casting repairs. To be used under the shield of Ar+O<sub>2</sub>.

## TYPICAL CHEMICAL COMPOSITION OF WIRE

C %	Mn %	Si %	S %	P %	Cr %	Ni %	Mo %	Cu %
0.08	0.60	0.60	0.010	0.010	2.50	-	1.0	0.12

## TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-40°C	-60°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
MIX	after PWHT	570	670	20	170	-	-	-	-

## WELDING GUIDELINES

Preheat and interpass temperature 200°C. PWHT at 690°C for an hour.

## TECHNICAL INFORMATION

Gas: Mix Ar- O<sub>2</sub> (EN ISO 14175)

Welding positions: all positions



## WELDING PARAMETERS

Current	DC + Reverse polarity			
Diameter (mm)	0.9	1.2	1.6	
Volts (V)	17 ÷ 30	18 ÷ 34	19 ÷ 38	
Current (A)	70 ÷ 240	100 ÷ 360	130 ÷ 450	

Diam.	5kg Spool	15kg Spool
0.9mm	INMB30905	INMB30915
1.2mm		INMB31215
1.6mm		INMB31615

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