FOR HEAT-RISISTING STEEL

AWS ER90S-B3
JIS YG2CM-G
EN SG CrMo2

KC-90SB3

Typical applications

2.25%Cr-1% Mo Heat Resistant steels

Characteristics on Usage

① Wide mixing range can be used, but generally 98%Ar+2%O_2 is recommended for KC-90SB3
② Excellent mechanical and toughness properties after PWHT
③ It is suitable to use shielding gas of 20 to 25ℓ /min.
④ Distance between a base plate and contact tip must be kept at around 6~15mm with current less than 250A, and around 15 ~ 25mm with current over than 250A.
⑤ Wind screen must be set at the welding in the place with strong wind
⑥ Preheat at 100℃ to 200℃ and post weld heat treatment at 620℃ to 720℃ is necessary according to the plate thickness, type of steels, shape of base metals or under high restriction.

Typical chemical composition of wire (%)

C	Si	Mn	Cr	Mo
0.09	0.47	0.66	2.31	1.00

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm²{kgf/mm²}	T · S N/mm²{kgf/mm²}	El (%)	Charpy V-notch J {kgf · m} (-18℃)
Ar+2%O_2	570 {58}	660 {67}	24	80 {8}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.4	1.6
Amp.	F	100~350	140~400	200~550
	V&OH	50~180	100~250	120~300

Package

Dia. (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Spool (kg)	5, 15, 20					
Pailpack (S)	200, 250			250, 300,		–
Pailpack (B)	–			350,400,450		

Approved by