

FOR HEAT-  
RESISTING STEEL

AWS ER80S-B2  
DIN SG CrMo2  
JIS YGT2CM

**T-90SB3**

## Typical applications

2.25%Cr-1%Mo Heat Resistant steels.

## Characteristics on Usage

- ① Ar Gas is mainly used for the shielding
- ② Excellent mechanical and toughness properties after PWHT.
- ③ Proper tungsten electrode extension from the tip of torch is 4~6mm in general.
- ④ Preheat at 150°C to 300°C and post weld heat treatment at 680°C to 730°C is necessary according to the plate thickness, type of steels, shape of base metals or under heat restriction.

## Typical chemical composition of rod (%)

C	Si	Mn	Cr	Mo
0.09	0.47	0.66	2.31	1.00

## Typical mechanical properties of all-weld-metal

Y · P	T · S	El	Charpy V-notch
N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	(%)	J {kgf · m} (0°C)
550 {56}	670 {68}	26	180 {18}

Approved by