TALARC B3 TIG

CLASSIFICATION

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

ALLOY TYPE

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

APPLICATIONS

Low alloy copper-coated tig rod with 2.25% Cr and 1% Mo content to be used for the welding of creep resistant steel. Chemical composition of rod 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.

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	0.15

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)
Argon	after PWHT	570	650	22	230	-	-	-	-

WELDING GUIDELINES

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

TECHNICAL INFORMATION

Gas: Argon 100% (EN ISO 14175)
Welding positions: all positions



WELDING PARAMETERS and PACKAGING DATA

Diameter (mm)	1.6	2.4
Length (mm)	1000	
Carton	5 Kg	
Current	DC - Straight (-) polarity	