



# KISWEL

## KISWEL – KD-B3

### Classifications:

AWS A5.23: EB3  
EN ISO 24598: S CrMo2 CS

JIS Z 3183: S642-2CM

### Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	Cr	S	Mo
0.05 – 0.15	0.05 – 0.30	0.40 – 0.80	2.25 – 3.00	<0.025	0.90 – 1.10

### Description:

- For power plants, heat exchangers and oil refinery applications for 2.25%Cr-1.0%Mo heat-resistant steel.
- Excellent mechanical and toughness properties after PWHT.
- Neutral flux for multi-pass welding.
- Excellent impact toughness and crack resistibility.

### Typical Mechanical Properties:

Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation (%)	Impact Value (J)
min. 610	min. 700	min. 23	70 (-20°C)

### Packaging:

**SAW Wire** (Ø in mm): 2.40 MM / 3.20 MM / 4.00 MM / 4.80 MM in 25.00 Kg Spools

### Welding Parameters:

Wire Diameter	Shielding Gas	Current (A)		Voltage (V)	
		Min.	Max.	Min.	Max.
2.40 mm		250	500	28	32
3.20 mm		300	650	28	32
4.00 mm	-	400	1200	30	34
4.80 mm		500	1400	32	36



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