



ENAR WELD BRAZE PVT. LTD

A-112, DDA INDUSTRIAL SHEDS,
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KISWEL – T-90SB3

Classifications:

EN ISO 21952-B: 2007: W 62 2C1M
AWS A5.28-05: ER90S-B3

KS D 7140: YGT2CM
JIS Z 3316: YGT2CM

Typical Chemistry Composition of Weld Deposit:

C	Si	Mn	P	S	Cr	Mo
0.07 – 0.12	0.40 – 0.70	0.40 – 0.70	<0.025	<0.025	2.30 – 2.70	0.90 – 1.20

Description:

- For butt and fillet welding of power plant, heat exchanger and oil refineries such as 2.25%Cr-1.0%Mo heat-resistant steel.
- Excellent mechanical and toughness properties after PWHT.
- Proper tungsten electrode extension from the tip of torch is 4~6mm in general.
- 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 high restriction.

Typical Mechanical Properties:

Yield Strength
(Mpa)
min. 540

Tensile Strength
(Mpa)
min. 620

Elongation
(%)
min. 17