

Mild and Low Alloy Steel TIG, MIG and SUB-ARC Wire

Oxford Alloy[®] 90S-B3

SPECIFICATIONS

AWS 5.28
ASME SFA 5.28

CLASSIFICATIONS

AWS ER90S-B3
UNS K30960

DESCRIPTION / APPLICATION

Oxford Alloy ER90S-B3 is designed for welding 2-1/4 Cr / 1 Mo steels, which are used for high temperature applications. A preheat and interpass temperature of not less than 350°F should be maintained during welding.

Note: Mechanical properties listed above reflect utilization of a post-weld heat treatment between 1250°F and 1300°F for one hour.

AWS Chemical Composition						
C	Mn	Si	Cr	Mo	P	S
0.07-0.12	0.40-0.70	0.40-0.70	2.30-2.70	0.90-1.20	0.025 max	0.025 max
Cu	Ni	OET				
0.35 max	0.20 max	0.50 max				

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 97,150 psi 670 MPa
Yield strength: 79,750 psi 550 MPa
Elongation: 26%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

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