



# TIG F68

Old reference: TIG 90SB3

## Classification

AWS A5.28 : ER90S-B3  
 ISO 21952-A : W Z CrMo2Si

Material N° : 1.7384

## Description & Applications

GTAW rods for welding creep resisting steels (alloyed with Cr and Mo) used in service up to 600°C (including 2% Cr- 1% Mo castings). High resistance to H2S...

**Main applications:** For overheaters, valve bodies, pipes, boilers, hydrocrackers.

### Base materials:

### Steels and pipes for boiler and pressure vessels:

NF A 36-206	: 15CD4-05 – 10CD9-10
DIN 17155 and 17245	: 10 Cr Mo 9.10 – 10 Cr Si Mo V7
	: 24 CrMo V55 – 12 Cr Mo 9.10 GS 12 Cr MO 9.10...
BS	: 1501 Gr 622 to 1504 Gr 622, BS 359 Gr 622/640 1503 Gr 660, 1504Gr 660
ASTM	: A 387 GrD – A 335 GrP 22 – A 213 GrT 22, T36

Nuance Vallourec: Chromesco 3

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Mo	Cu	P	S	Fe
0.1	0.6	0.6	2.4	1.0	0.2	<0.015	<0.015	Rem.

## All Weld Metal Mechanical Properties

R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> ( % )	KV ( J )
550	630	22	+20°C 180
After PWHT 700°C/1h			

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Nitrogen / H <sub>2</sub> : 3-6 l/min

ind.10



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