



SWASTIK-WELD

JINIK MARKETING

Swastik Weld Make Welding Wire GMAW/GTAW (MIG & TIG) for Carbon Steel

V) ER 90S-B9 CLASSIFICATION: AWS A/SFA 5.28

Chemical Composition of ER 90S-B9 Wire

C= 0.07-0.13

Mn= 1.20 max

Si= 0.15-0.50

Cr= 8.0-10.50

Mo= 0.85-1.20

Ni= 0.80 max

V=0.15-0.30

Cu= 0.20 max

Al= 0.04 max

N= 0.03-0.07

S= 0.010 Max

P= 0.010 max



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MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS, Mpa= 620 min

EL%= 16 min

TYPICAL APPLICATION OF 90S-B9:

- 1) Typical 9Cr-1Mo-V-Nb type weld deposit
- 2) Suitable for welding of Cr-Mo-V-Nb steels such as P91, T91 and F91
- 3) Suitable for material 1.4903, SA 387 Gr.91, SA 213 T91, SA 335 P91
- 4) For heavy wall components such as headers, main steam piping and turbine rotors in power generation plants

Packing: Tig: In cut length of 1000mm in 5kgs boxes (size: 1.6, 2.0, 2.40, 3.15mm)

Mig: Continuous wire in 12.5kgs / 15kgs Plastic Spool (size: 0.80, 1.2mm)

**Works: Gala No. 19, Syndicate Indl. Complex, Near Golani Naka, Near Bank of Maharashtra,
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