Inweld 90S-B9

AWS A5.28 ER90S-B9

Chemical Composition of Inweld 90S-B9

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cb
Balance	0.09	9.10	0.55	1.00	0.95	0.23	0.006	0.004	0.04	0.06

Single values are maximum unless otherwise specified

Description and Applications

Inweld 90S-B9 is 9% chrome, 1% moly wire with micro alloying elements of vanadium and columbium. This wire is specially designed to provide strength, toughness, in addition to oxidation resistance and corrosion resistance at elevated temperatures. The welds have higher creep resistance at high temperatures compared with regular 9% chrome + 1% moly welds.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	96,000 psi
Yield Strength:	81,500 psi
Elongation:	17%

Recommended Parameters

GMAW

Wire Diameter	Voltage	Amperage
0.035”	14-20	90-160
0.045”	16-20	120-200
1/16”	---	---

GTAW

Wire Diameter	Voltage	Amperage
0.035”	7-13	50-120
0.045”	10-16	120-200
1/16”	12-18	150-220