

**Specifications:**

AWS A5.28/ ASME SFA 5.28  
 AWS ER90S-B3  
 UNS K30960

**Properties:**

**Tensile Strength:** 90,000 psi min.  
**Yield Strength:** 78,000 psi min  
**Elongation:** 17% min.

**Description:**

WT 90S-B3 is a creep resistant steel that need control of interpass temperatures, preheat and post heat is needed to avoid cracking. With this care is also needed when using this wire in the as-welded condition due to its high strength levels. It is often used in chemical industries for pipelines and pressure vessels with temperatures of around 1100°F. While preheat and interpass temperatures are usually kept between 375-425°F, and post weld heat temperatures are usually 1275°F for 1 hour.

Available in multiple sizes and diameters.

**Chemical Composition (Wt%):**

Si	Mn	S	P	C	Cu	Mo	Ni	Cr
0.40-0.70	0.40-0.70	0.025	0.025	0.07-0.12	0.35	0.9-1.2	0.2	2.3-2.7

Note: Single values are maximum unless otherwise noted

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.