

DT-1.4519

Stainless Steel MIG/MAG-Wire TIG – Rods

Specifications

ISO 14343-A : G/W 20 25 5 Cu L
 ISO 14343-B : SS385
 ASTM/AWS/SFA-5.9: ER 385

Application

Stainless steel; resistant to intercrystalline corrosion and wet corrosion up to 350°C. Good corrosion resistance similar to matching steels/cast steel grades, above all in reducing environments. For joining and surfacing work with matching austenitic CrNiMoCu steels/cast steel grades. For joining these steels with unalloyed/low-alloy steels/cast grades.

Chemical Composition Element by weight (%)

C: 0,02 Si: 0,20 Mn: 2,0 Cr : 20,0 Mo:4,5
 Ni: 25,0 Cu: 1,5

Mechanical Properties (typical)

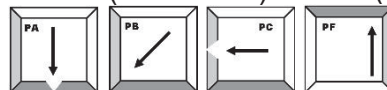
Yield Strength (Re) 380 N/mm²
 Tensile Strength (Rm) 560 N/mm²
 Elongation (A)(Lo=5do) 35%
 Impact energy (Av) 80 J
 High temp. 350° C
 Low temp. -196° C

Approvals

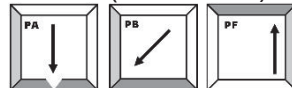
TÜV, DB, CE-Zeichen

Shielding gas/Polarity

WIG: (ISO 14175) I1 (= -)



MSG: (ISO 14175) M12 (= +)



Typical Base Material

1.4500 1.4536 1.4539 1.4505 1.4506

Packaging

MIG/MAG: spools D 100 / D 200 / K 200 / K 300
 TIG: 5-kg-boxes