


904L Tig

CATEGORY	GMAW-GTAW Solid wires									
TYPE	Solid stainless steel austenitic filler metal with excellent corrosion resistance for Tig welding									
APPLICATIONS	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants									
PROPERTIES	The Ceweld 904L is used for welding materials of similar chemical composition which are used for fabrication of equipment and vessels for handling of sulfuric acid and many chloride containing media. This filler metal may also find applications for joining Type 317L material where improved corrosion resistance in specific media is needed. In order to reduce the propensity for fissuring and hot cracking, the low melting constituents such as carbon, silicon, and phosphorus are controlled to lower levels in this alloy.									
CLASSIFICATION	AWS	A 5.9: ER 385								
	EN ISO	14343-A: W 20 25 5 Cu L 14343-A: SS385								
	DIN: W.Nr.	1.4539								
	DIN	8556: ~20 25 5 L Cu								
SUITABLE FOR	W.Nrs: 1.4500, 1.4505, 1.4506, 1.4519, 1.4531, 1.4536, 1.4539, 1.4573, 1.4585, 1.4586, 4 NS N 08904 1.4539, 1.4537, 1.4519, 1.4505, UNS N08904, S31726, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X4NiCrMoCuNb 20-18-2, Uranus B6									
APPROVALS	CE approved									
WELDING POSITIONS:										
WELD DEPOSIT WEIGHT (TYPICAL) %										
	C	Mn	Si	Cr	Ni	Mo	N	Cu	P	S
	0.019	2.05	0.35	20.5	25.1	4.6	0.04	1.6	0.014	0.015
TYPICAL WELD METAL PROPERTIES										
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV			
AW	410	600	35	+20°C	-40°C	-60°C				
AW: as welded										
WELDING PARAMETERS / PACKING										
	Welding Parameters					Packing (kg)				
D (mm)	Current (A) DC-					single	master			
1.6 x 1000	50-80					5	25			
2.0 x 1000	70-110					5	25			
2.4 x 1000	110-180					5	25			
3.2 x 1000	150-250					5	25			
REDRYING TEMPERATURE	Not required									
GAS ACC. EN ISO 14175:	I1									