

## AA 904L

**CATEGORY** FCAW Flux-Cored

**TYPE** Rutile fluxcored austenitic filler metal with excellent corrosion resistance

**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 AA 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 fluxcored wire 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 5.22: E 385LT0-1/-4*
EN ISO	17633-A: T 20 25 5 Cu N L P M 2
DIN: W.Nr.	1.4539
DIN	8556: 20 25 5 L Cu

**SUITABLE FOR** W.Nrs: 1.4500, 1.4505, 1.4506, 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:**



**ALL WELD METAL WEIGHT %**

C	Si	Mn	P	S	Ni	Cr	Mo	N	Cu
0.03	0.66	1.56	0.024	0.003	25.3	20.9	4.8	0.13	1.34

**ALL WELD MECHANICAL PROPERTIES (TYPICAL)**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-196°C	
as welded	423	664	36			61	

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	25	160	BS-300	15	1080

**REDRYING TEMPERATURE** 150°C/24hr

**GAS ACC. EN ISO 14175:** M21