

904L

CATEGORY	GMAW-GTAW Solid wires										
TYPE	Solid stainless steel 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 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: G 20 25 5 Cu L 14343-B: 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)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc / HV				
AW	>380	>560	>35	+20°C	-40°C	-60°C					
AW: as welded											
WELDING PARAMETERS / PACKING											
Welding Parameters			Packing								
D (mm)	Voltage (V)	Current (A) DC+	spool type		kg / spool / Drum		kg / pallet				
0.8	16-22	50-140	S-300 / Drum		15 / 250		1080 / 1000				
1.0	16-24	80-190	S-300 / Drum		15 / 250		1080 / 1000				
1.2	20-28	180-280	S-300 / Drum		15 / 250		1080 / 1000				
REDRYING TEMPERATURE	Not required										
GAS ACC. EN ISO 14175:	M12, M13										