Technical data sheet 011121MBA	Cored welding wire # TUBE S 904L-S	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.22 / AWS A 5.22:	EC385
ASME IIC SFA 5.9 / AWS A 5.9:	EC385
EN ISO 17633-A:	T Z 20 25 5 Cu L M NO 3
Equivalent Material number:	1.4519
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 9

DESCRIPTION

- Metal cored stainless steel wire for submerged arc welding
- 20% chromium - 25% nickel - 4.5% molybdenum - 1.5% copper - low carbon deposit
- Attractive bead appearance without residual slag, outstanding slag release even in narrow gaps
- High productivity and enhanced wetting properties compared to matching solid wires
- Mineral additions to the core improve both mechanical characteristics and resistance to cracking

APPLICATIONS

TUBE S 904L-S is suitable for welding and cladding stainless steels of similar composition and for dissimilar welds between these steels and mild, low alloy and other stainless steels. It is an alternative choice to overmatch leaner alloys such as 317LN, 1.4439 etc.

Examples:

AISI	UNS	Material number	EN Symbol
		1.4500	GX7 NiCrMoCuNb 25-20
		1.4505	X4 NiCrMoCuNb 20-18-2
		1.4506	X5 NiCrMoCuTi 20-18
		1.4536	GX2 NiCrMoCuN 25-20
	N08904	1.4539	X1 NiCrMoCu 25-20-5
		1.4585	GX7 CrNiMoCuNb 18-18

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.015	2.30	0.50	21.0	26.0	5.00	1.60	0.010	0.020

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
510	320	25	-196°C: 32

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
640	410	35	- 196°C: 45

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

PACKAGING

Diameter	1.6 mm - 3.2 mm
Standard packaging	EN ISO 544 - ASME IIC SFA-5.2 M
	Coil: B450
Weight	25 kg

Other packaging and other diameters: please consult us