



AWS A5.9: ER385
ISO 14343-A-2009 25 20 5 Cu L

Super Austenitic Solid Wire

MIG/TIG Welding

SW-904L

DESCRIPTION & APPLICATION

MIG/TIG Filler wire for the joining and overlay of Stainless Steels of similar composition (904L). Due to its alloy composition, high Mo-content and Cu, the weld metal is suited against attacks by phosphoric and sulphuric acids, it shows a high resistance against pitting and stress corrosion in chloride containing media.

BASE MATERIALS

UNS S 31703. N 08904. Werkstoffe No. 1.4563, 1.4539.
Creusot Loire Uranus B28, B6, Sanicro 28.

MECHANICAL PROPERTIES

~650n/mm
UTS n/mm

>490
YIELD 0.2%

>35
ELONG A5%

>100 (ISO-V)
IMPACT (J)-196°C

METAL WELD COMPOSITION %

C	Si	Mn	Cr	Ni	Mo	S	P	Cu	Fe
0.008	0.35	1.9	20	25	4.31	0.01	0.01	1.4	BAL

PACKAGING

15kg Spools (MIG)
5kg Tubes (TIG)

DIAMETERS

0.8, 1.0, 1.2mm (MIG)
1.6, 2.4, 3.2mm (TIG)

WELDING INSTRUCTIONS

Shielding gas MIG <3%, 2% Argon-Ox or proprietary special gas. TIG 100% Argon. Do not allow the base material to overheat, maintain interpass temperature below 150°C.