



# Selectarc Inox 385

*Stainless Electrode  
Highly corrosion resistant*

## Classification

AWS A5.4 : E385-16      EN 1600 : E 20 25 5 Cu N L R 1 2  
ISO 3581-A : E 20 25 5 Cu N L R 1 2

## Description & Applications

Rutile-basic coated electrode for welding fully austenitic highly corrosion resistant stainless steels as 904L, B6 . Good weldability in all positions, except vertical down, stable arc, good slag removal, regular finely rippled weld beads. 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. It is used at operation temperatures up to 400°C.

**Main applications:** Pulp and paper industry, transport containers, installations of the chemical industry.

## Base materials

UNS	Alloy	EN	Material N°	CLI
S31703	317 L	X2CrNiMo18-15-4	1.4438	
	317 LNM	X2CrNiMoN17-13-5	1.4439	
		G-X7NiCrMoCuNb 25-20	1.4500	
		X5CrNiMoCuTi 20-18	1.4506	
N08904	904L	X1NiCrMoCu25-20-5	1.4539	URB6(N)

## Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	Fe
<0.03	0.8	1.4	20.5	25.0	4.5	1.5	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0,2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
>370	>570	>35	+20°C >70

## Welding Current & Instructions

Electrode	ØxL ( mm )	2,5x300	3,2x350	4,0x350
Current	( A )	50-70	70-100	90-130

Redrying 2-3h at 250-300°C. Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter). Interpass temperature : < 150°C.

ind.12



= + ~ 70V



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