

## TIGWELD 385

TIG Rods [GTAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : W 20 25 5 Cu L DIN 8556 : SG-X2 CrNiMoCu20 25 AWS A-5.9 : ER 385 W.Nr. : 1.4539		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Petrochemical and chemical industry

- TIG rod for welding corrosion-resistant CrNi steels with Mo content of 4-5%.
- Pitting resistance equivalent PREN  $\geq 45$ .
- Fully austenitic deposit, resists pitting and crevice corrosion in chloride media.
- High resistance to sulfuric, phosphoric, acetic and formic acids.
- Resistant to sea and brackish water.
- Reduced risk of intergranular corrosion due to low carbon content.
- High nickel content provides high resistance to corrosion and stress cracking.

### Application

Used to make joints on 316 steel or similar alloys when the weld metal must be completely free of ferrite. Most often for URANA B-6 and B6M steel, NAR-20-25LMCu, UHB 904L, Sandvik2RK65, Cronifer 1925LC, Avesta254SLX, HV-9A, HV-9, Carpenter 20. It is used in the production of equipment and constructions for handling sulfuric, phosphoric, acetic, and formic acids.

### Base material

EN	W.Nr.	AISI/ASME
X1NiCrMoCu 25 20 5	1.4539	904L
X2CrNiMoN 17 13 5	1.4439	317LMN
X1CrNiMoCuN 25 25 5	1.4537	
GX7 NiCrMoCuNb 25 20	1.4500	
X5NiCrMoCuTi 20 18	1.4506	
GX2NiCrMoCuN 20 18	1.4531	
GX2NiCrMoCuN 25 20	1.4536	
GX7CrNiMoCuNb 18 18	1.4585	
X5NiCrMoCuNb 22 18	1.4586	
X2 CrNiMo18 16 4	1.4438	317L, TP 317L
G-X2 CrNiMoN17 13 4	1.4446	
X5 NiCrMoCuNb20 18 2	1.4505	

### Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	N	Cu
0,019	0,35	2,05	20,50	25,10	4,60	0,04	1,60

### Typical mechanical properties

Yield strength Re [N/mm <sup>2</sup> ]	>410
Tensile strength Rm [N/mm <sup>2</sup> ]	>600
Elongation A5 [%]	>35
Impact energy Kv [J]	>120 J (20°C) /
Wire/rod type	solid



**Welding positions**



**Shielding gases acc. to EN ISO 14175**

I1 - Ar / I3 - Ar + >0-95% He /

**Welding parameters and packing**

∅	Length [mm]	Weight of packet [kg]
1,6	1000 /	5,0
2,0	1000 /	5,0
2,4	1000 /	5,0
3,2	1000 /	5,0

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