

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 ≥ 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 ²]	>410
Tensile strength Rm [N/mm ²]	>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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