INOX R385

Electrodes MMA [SMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 3581-A : E 20 25 5 Cu N L R 32 DIN 8556 : E 20255LCu R 23 AWS A-5.4 : E 385-16 W.Nr. : 1.4519		Power generation industry Constructions & Engineering Petrochemical and chemical industry

- High-alloy electrode with an alloyed core for welding corrosion-resistant steels such as CrNiMoCu grade or similar.
- The weld is particularly resistant to stress corrosion cracking, especially sulfuric and phosphoric acids.
- Recommended for welding steels with high molybdenum content.

Application

Used to make joints on 316 steel or similar where ferrite cannot be present in the weld metal. 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 structures for handling sulfuric and phosphoric acid, vinegar, formic.

Base material

DIN	W.Nr.	AISI/ASME	PN
G-X7NiCrMoCuNb2520	1.4500		
X5NiCrMoCuNb20182	1.4505		
X5NiCrMoCuTi2018	1.4506		
X5NiCrMoCuNb2218	1.4586		
X2NiCrMoCuN2018	1.4538		
X1NiCrMoCuN25205	1.4539	904L	OH22N24M4TCu
G-XNiCrMoCuN2520	1.4536		
X2 CrNiMo18 16 4	1.4438	317L	
X3 CrNiMoN17 13 5	1.4439	317LN	
G-X2 CrNiMoN17 13 4	1.4446		
G-X2 NiCrMoCuN20 18	1.4531		

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	Cu
<0,03	0,90	1,50	20,00	25,00	4,50	1,50

Typical mechanical properties

Yield strength Re [N/mm2]	not required, typ. >400
Tensile strength Rm [N/mm2]	>520
Elongation A5 [%]	>28
Impact energy Kv [J]	>55J (20°C) /
Coating type	rutile-basic
Ferrite content	FN = app. 0
Welding current	

Welding positions	
Redrying	300 - 350°C / 2 h
Additional description	PREN = 35 Fully austenitic microstructure after welding. Interpass temperature max 150[°C].

Welding parameters and packing

ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
2,5	300 /	50-80	1,5	9,0
3,2	350 /	80-110	1,5	9,0
4,0	350 /	100-150	1,5	9,0

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