MIGWELD 385

MIG/MAG Wires [GMAW]

Stainless and high alloyed steels

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14343-A : G 20 25 5 Cu L DIN 8556 : S-GX2 CrNiMoCu20 25 AWS A-5.9 : ER 385 W.Nr. : 1.4539		Power generation industry Constructions & Engineering Metallurgy (Steelworks) Petrochemical and chemical industry

- Solid wire for welding materials of similar chemical composition, which are used in the manufacture of equipment and tanks for the storage of sulfuric acid and substances with a high content of chlorine compounds.
- The weld metal is also used in welding type 317L materials where higher corrosion resistance is needed.
- Very low content of elements such as: carbon, silicon and phosphorus, which helps to avoid cold and hot cracking.
- Recommended for welding steels with high molybdenum content.

Application

Used to make joints on 316 or similar alloys when the weld metal must be free from ferrite. Commonly used for steels such as for URANA B-6 and B6M steel, NAR-20-25LMCu, UHB 904L, Sandvik2RK65, Cronifer 1925LC, Avesta254SLX, HV-9A, HV-9, Carpenter 20. It finds application in the production of equipment and structures for handling sulfuric, phosphoric, acetic, and formic acid.

Base material

DIN	W.Nr.	AISI/ASME
X1 NiCrMoCu25-20-5	1.4539	904L
X2 CrNiMoN 17-13-5	1.4439	317LMN
X1 CrNiMoCuN 25-25-5	1.4537	
X4 NiCrMoCuNb20-18-2	1.4505	
X5 NiCrMoCuTi20-18	1.4506	
G-X2 NiCrMoCuN20-18	1.4531	
G-X2 NiCrMoCuN25-20	1.4536	
X10 CrNiMoTi18-12	1.4573	
G-X7 CrNiMoCuNb18-18	1.4585	
X5 NiCrMoCuNb22-18	1.4586	
G-X7 NiCrMoCuNb25 20	1.4500	
X2 CrNiMo18 16 4	1.4438	317L, TP 317L
G-X2 CrNiMoN17 13 4	1.4446	
X2 CrNiMoCu25 20 6	1.4529	926
ISO 2025 5 CuL	1.4519	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo
0,019	0,35	2,05	20,50	24,59	4,60

Typical mechanical properties

Yield strength Re [N/mm2]	410
Tensile strength Rm [N/mm2]	>600
Elongation A5 [%]	>35

Impact energy Kv [J]	>120J (20°C) /
Wire/rod type	Solid
Welding current	
Welding positions	
Shielding gases acc. to EN ISO 14175	M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

⌀	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	100-160	18-22	15,0
1,0	140-200	18-24	15,0
1,2	170-260	20-28	15,0
1,6	220-350	24-36	15,0

METALWELD-FIPROM POLSKA spółka z o.o.

ul. Mikołajczyka 57, 41-200 Sosnowiec

+48 (32) 297 75 50 - 51

+48 (32) 297 75 88

export@metalweld.pl