

ROYAL -ER 385 Stainless Steel Solid Filler Wire Rods

AWS/ SFA A 5.9 ER 385

Description

This solid filler wire rods deposit 20.5 % Cr, 25 % Ni, 4.7 % Mo and 1.5 % Cu weld metal with good finish and free from any defects.

Typical Applications

It is used for welding of ASTM B625, B673, B674 and B677 material for handling of sulphuric acid and many chlorides containing. Media; for welding of type 904L material.

Packing

Each Packets content 5 kg of Wire Rods having length 1000mm

Also available in MIG wire Size 0.80 , 1.00, 1.20, 1.60 mm in 12.5 kg Spool.

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%	Cu%
0.025Max	1.00 – 2.50	0.50 Max	0.03 Max	0.02 Max	19.5 - 21.5	24.0– 26.0	4.20 - 5.20	1.20-2.0

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	ELONGATION (L = 4d) %	Shielding Gas
520	30 % Min	Ar + 2% Oxygen