



TIGINOX 385

GTAW STAINLESS STEEL

AWS A/SFA 5.9 ER385

CLASSIFICATION:

EN ISO 14343-A
W 20 25 5 Cu L

KEY FEATURES:

- Low carbon 20/25/5/Cu type TIG rod
- Resist intergranular corrosion and sulfide stress corrosion cracking
- Resistant to pitting and crevice corrosion in chloride bearing media
- Recommended for highly corrosive conditions in the chemical industries, sea water desalination plants
- Radiographic quality welds

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 904L, HV-9A, HV-9 stainless steel and similar alloys for high temperature and high corrosion service
- Welding of 904L steel to other grades of stainless steel
- Welding of austenitic stainless steels with enhanced corrosion resistance to reducing media


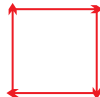
TYPICAL CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt %:

C	Mn	Si	Cr	Ni	Mo	Cu
0.023	1.9	0.4	19.9	24.3	4.4	1.4

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	590	36

PARAMETERS - PACKING DATA:

Ø, mm	Net Wt, Kg		
1.6 x 1000	20	 DCEN STORAGE / HANDLING : Keep dry during storage and handling	All Positions 
2.0 x 1000	20		
2.4 x 1000	20		

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

Available in Standard carton packing of 20 kg box, containing 4 plastic tubes of 5 kg each.