



# CEWELD 904L

TYPE	Stainless steel welding wire 904L with excellent corrosion resistance														
APPLICATIONS	CEWELD® 904L is a corrosion-resistant, solid chromium-nickel-molybdenum-copper wire for welding austenitic stainless alloys with 20% Cr, 25% Ni, 5% Mo, 1.5% Cu, and low carbon content. Typical applications include process vessels and tanks, piping systems, agitators and rotors, as well as cast pumps and valves for the production of fertilizers, phosphoric, sulfur, and acetic acids. It is also suitable for brackish and seawater environments and in some offshore applications.														
PROPERTIES	CEWELD® 904L can also be used to join Type 317L materials when improved corrosion resistance in certain media is required. To reduce the tendency to crack and hot crack, the low-melting components such as carbon, silicon, and phosphorus in this alloy are limited to a lower content. Good general corrosion resistance similar to that of similar steels/ cast steels, especially in reducing environments. Max. operating temperature 350°C.														
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER385</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: G 20 25 5 Cu L</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> <tr> <td>W.Nr.</td> <td>1.4539</td> </tr> </table>	AWS	A 5.9: ER385	EN ISO	14343-A: G 20 25 5 Cu L	F-nr	6	FM	5	W.Nr.	1.4539				
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SUITABLE FOR	<p><b>1.4539 / 904L CrNiMoCu / 20 25 5 Cu L</b>            1.4465, 1.4500, 1.4505, 1.4506, 1.4519, 1.4531, 1.4536, 1.4537, 1.4538, 1.4539, 1.4573, 1.4585, 1.4586            X1CrNiMoN25-25-2, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X2NiCrMoCuN25-20-5, X2NiCrMoCuN20-18, X4NiCrMoCuNb 20-18-2, X5NiCrMoCuTi20-18, X5NiCrMoCuNb22-18            ASTM A182,            UNS N08904, S31726            Uranus B6, AISI 904L, Z2NCDU25-20,</p>														
APPROVALS	CE														
WELDING POSITIONS															
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.019</td> <td>0.35</td> <td>2</td> <td>20.5</td> <td>25</td> <td>4.6</td> <td>1.6</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Cu	0.019	0.35	2	20.5	25	4.6	1.6
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As Welded /	380	560	35	RT 70											
REDRYING TEMPERATURE	Not required														
GAS ACCORDING EN 14175	M13, M12														



# CEWELD 904L

904L 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663415400

904L 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663415417

904L 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663415424