




CEWELD SA 904L

TYPE	SAW stainless steel austenitic filler metal with excelent corrosion resistance								
APPLICATIONS	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants								
PROPERTIES	SA 904L is used for welding materials of similar chemical composition which are used for fabrication of equipment and vessels for handling of sulfuric acid and many chloride containing media. This filler metal may also find applications for joining Type 317L material where improved corrosion resistance in specific media is needed. In order to reduce the propensity for fissuring and hot cracking, the low melting constituents such as carbon, silicon, and phosphorus are controlled to lower levels in this alloy. Fluxes to be used with our fused flux FL 880 or agglomerated flux FL 838.								
CLASSIFICATION	AWS	A 5.9: ER385							
	EN ISO	14343-A: S 20 25 5 Cu L							
	F-nr	6							
	FM	5							
	W.Nr.	1.4539							
SUITABLE FOR	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, 1.4539, 1.4537, 1.4519, 1.4505 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, 904L, Z2NCDU25-20,								
APPROVALS	CE								
WELDING POSITIONS	<div> PA</div> <div> PB</div> <div> PC</div>								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
	0.019	0.35	2.05	0.01	0.01	20.5	25	4.6	1.6
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT				
	As Welded /	390	570	35	70				
REDRYING TEMPERATURE	Not required								
GAS ACCORDING EN 14175									



CEWELD SA 904L

SA 904L 2,4MM

Type	KG/unit	EANCode
K-415	25	8720663415431

SA 904L 3,2MM

Type	KG/unit	EANCode
K-415	25	8720663415448