



CEWELD 904L Tig

TYPE	Solid stainless steel austenitic filler metal with excellent corrosion resistance for Tig welding																		
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	The Ceweld 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.																		
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER385</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: W 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: W 20 25 5 Cu L	F-nr	6	FM	5	W.Nr.	1.4539								
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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																			
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</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>0.01</td> <td>0.01</td> <td>20</td> <td>25</td> <td>4.5</td> <td>1.6</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	0.019	0.35	2	0.01	0.01	20	25	4.5	1.6
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> <th>Impact Energy (J) ISO-V RT</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>410</td> <td>600</td> <td>35</td> <td>120</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	As Welded /	410	600	35	120								
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As Welded /	410	600	35	120															
REDRYING TEMPERATURE	Not required																		
GAS ACCORDING EN 14175	I1																		



CEWELD 904L Tig

904L TIG 1,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663415349

904L TIG 1,6 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663415356

904L TIG 2,0 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663415363

904L TIG 2,4 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663415370

904L TIG 3,2 X 1000MM

Type	KG/unit	EANCode
Tube	5	8720663415387