CEWELD 904L Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid stainless steel austenitic filler metal with excelent corrosion resistance for Tig welding

APPLICATIONS

CEWELD® 904L Tig 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 Tig 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

AWS	A 5.9: ER385
EN ISO	14343-A: W 20 25 5 Cu L
F-nr	6
FM	5
W.Nr.	1.4539

SUITABLE FOR

1.4539 / 904L CrNiMoCu / 20 25 5 Cu L
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,

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.019	0.35	2	0.01	0.01	20	25	4.5	1.6

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	410	600	35	120

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

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	Type	KG/unit	EANCode
904L TIG 1,2 X 1000MM	Tube	5	8720663415349
904L TIG 1,6 X 1000MM	Tube	5	8720663415356
904L TIG 2,0 X 1000MM	Tube	5	8720663415363
904L TIG 2,4 X 1000MM	Tube	5	8720663415370
904L TIG 3,2 X 1000MM	Tube	5	8720663415387