










# CEWELD 904L Tig

|   |  |                          |                       |                       |                               |    |    |     |     |
|---|--|--------------------------|-----------------------|-----------------------|-------------------------------|----|----|-----|-----|
| TYPE  | Solid stainless steel austenitic filler metal with excelent 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                                    | 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                                      | 1.4465, 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<br>X1CrNiMoN25-25-2, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X2NiCrMoCuN25-20-5, X2NiCrMoCuN20-18, X4NiCrMoCuNb 20-18-2, X5NiCrMoCuTi20-18, X5NiCrMoCuNb22-18<br>ASTM A182,<br>UNS N08904, S31726<br>Uranus B6, 904L, Z2NCDU25-20,   |                          |                       |                       |                               |    |    |     |     |
| APPROVALS   | CE   |                          |                       |                       |                               |    |    |     |     |
| WELDING POSITIONS                                 | <div>      </div> |                          |                       |                       |                               |    |    |     |     |
| 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 <sub>P0,2</sub><br>MPa | R <sub>m</sub><br>MPa | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V<br>RT |    |    |     |     |
|   | 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 |