CEWELD AA 904LP

certilas® THE FILLER METAL SPECIALIST

TYPE	Rutile fluxcored 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	The Ceweld AA 904LP 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 fluxcored wire 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. Suitable in all positions.

CLASSIFICATION

AWS	A 5.22: ~385T1-4
EN ISO	17633-A: T 20 25 5 Cu N L P M21 2
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

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	P	Cr	Ni	Mo	N	Cu
0.03	0.65	1.55	0.025	21	25.5	5	0.15	1.35

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -196°C
As Welded /	425	665	35	60

REDRYING TEMPERATURE

140°C / 24 hr

GAS ACCORDING EN 14175

M21

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AA 904LP 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663413734