



CEWELD ER 383

TYPE	ER 383 Stainless steel Mag welding wire for the GMAW process									
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	ER 383 is used to weld base metals of similar composition to itself or to other grades of stainless steel. ER383 contains a low maximum of carbon, silicon, and sulfur to decrease the hot cracking and fissuring, while maintaining the resistance to corrosion.									
CLASSIFICATION	AWS	A 5.9: ER383								
	EN ISO	14343-A: G 27 31 4 Cu L								
	F-nr	6								
	FM	5								
	W.Nr.	1.4563								
SUITABLE FOR	Alloy 825 N08825 , Alloy 825 h Mo N08821, Alloy 28 and Alloy 20 (X1NiCrMoCu31-27-4), Alloy 904L (X1NiCrMoCu25-20-5), 1.4563, 1.4539, NiCr 21 Mo 2.4858, NiCr 21 Mo 6Cu 2.6410, X3NiCrCuMoTi27-23 1.4503									
APPROVALS	CE									
WELDING POSITIONS										
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu
	0.02	0.4	1.55	0.017	0.01	28.2	32.1	3.9	0.05	0.95
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V					
	As Welded /	380	570	38	RT					
					100					
REDRYING TEMPERATURE	Not required									
GAS ACCORDING EN 14175	I1, M21, I3									