



# 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	PA  PB  PC																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C 0.02	Si 0.4	Mn 1.55	P 0.017	S 0.01	Cr 28.2	Ni 32.1	Mo 3.9	N 0.05	Cu 0.95								
ALL WELD MECHANICAL PROPERTIES	Heat Treatment As Welded /	R <sub>P0,2</sub> MPa 380	Rm MPa 570	A5 (%) 38	Impact Energy (J) ISO-V RT 100													
REDRYING TEMPERATURE	Not required																	
GAS ACCORDING EN 14175	I1, M21, I3																	