



GMAW / GTAW STAINLESS STEEL
TIGINOX 385

HIGH ALLOYED STAINLESS STEEL TIG ROD WITH SUPERIOR CORROSION RESISTANCE



CLASSIFICATION : EN ISO 14343-A AWS A/SFA 5.9

W 20 25 5 Cu L ER385

KEY FEATURES :

- Low carbon 20/25/5/Cu type TIG rod
- Resist intergranular corrosion and sulfide stress corrosion cracking
- Resistant to pitting and crevice corrosion in chloride bearing media
- Recommended for highly corrosive conditions in the chemical industries, sea water desalination plants
- Radiographic quality welds

WELDING POSITION :



GMAW: DCEN

Shielding Gas	Gas Flow Rate, LPM
Ar	10-15

TYPICAL APPLICATIONS :

- Welding of 904L, HV-9A, HV-9 stainless steel and similar alloys for high temperature and high corrosion service
- Welding of 904L steel to other grades of stainless steel
- Welding of austenitic stainless steels with enhanced corrosion resistance to reducing media

STORAGE / HANDLING :

Keep dry during storage and handling

CHEMICAL COMPOSITION OF BARE SOLID WIRE, Wt% :

	C	Mn	Si	Cr	Ni
Specification	0.025 max	1.0-2.5	0.50 max	19.5-21.5	24.0-26.0
	Mo	Cu	S	P	
Specification	4.2-5.2	1.2-2.0	0.03 max	0.02 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Specification	As Welded	520 min	30 min

PACKING DATA :

Ø, mm	Primary Box, Kg	No. of Primary Boxes	Net Wt. of Carton, Kg
1.6 x 1000	5	4	20
2.0 x 1000	5	4	20
2.5 x 1000	5	4	20