




# CEWELD ER 383

<b>TYPE</b>	ER 385 Stainless steel Mag welding wire for the GMAW process																													
<b>ANWENDUNGEN</b>	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants																													
<b>EIGENSCHAFTEN</b>	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.																													
<b>KLASSIFIKATION</b>	AWS	A 5.9: ER383																												
	EN ISO	14343-A: G 27 31 4 Cu L																												
	W.Nr.	1.4563																												
	F-nr	6																												
	FM	5																												
<b>GEEIGNET FÜR</b>	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																													
<b>ZULASSUNGEN</b>	CE																													
<b>SCHWEISSPOSITIONEN</b>																														
<b>TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.4</td> <td>1.55</td> <td>0.017</td> <td>0.01</td> <td>28.2</td> <td>32.1</td> <td>3.9</td> <td>0.05</td> <td>0.95</td> </tr> </tbody> </table>										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
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<b>RÜCKTROCKNUNG</b>	Not required																													
<b>GAS ACC. EN ISO 14175</b>	I1, M21, I3																													