




CEWELD 904L

TYPE	Stainless steel welding wire 904L with excellent 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® 904L 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 filler metal 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.																					
CLASSIFICATION	AWS	A 5.9: ER385																				
	EN ISO	14343-A: G 20 25 5 Cu L																				
	W.Nr.	1.4539																				
	F-nr	6																				
	FM	5																				
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 THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.019</td> <td>0.35</td> <td>2</td> <td>20.5</td> <td>25</td> <td>4.6</td> <td>1.6</td> </tr> </tbody> </table>						C	Si	Mn	Cr	Ni	Mo	Cu	0.019	0.35	2	20.5	25	4.6	1.6		
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				RT																		
As Welded	380	560	35	70		HRC																
REDRYING	Not required																					
GAS ACC. EN ISO 14175	M13, M12																					



CEWELD 904L

904L 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415400

904L 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415417

904L 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415424