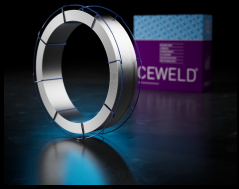


CEWELD SA 904L

TYPE	SAW stainless steel austenitic filler metal 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																										
PROPRIÉTÉS	SA 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. Fluxes to be used with our fused flux FL 880 or agglomerated flux FL 838.																										
CLASSIFICATION	AWS	A 5.9: ER385																									
	EN ISO	14343-A: S 20 25 5 Cu L																									
	W.Nr.	1.4539																									
	F-nr	6																									
	FM	5																									
CONVIENT POUR	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,																										
AGRÉMENTS	CE																										
POSITIONS DE SOUDAGE																											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<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>Cu</th> </tr> </thead> <tbody> <tr> <td>0.019</td> <td>0.35</td> <td>2.05</td> <td>0.01</td> <td>0.01</td> <td>20.5</td> <td>25</td> <td>4.6</td> <td>1.6</td> </tr> </tbody> </table>									C	Si	Mn	P	S	Cr	Ni	Mo	Cu	0.019	0.35	2.05	0.01	0.01	20.5	25	4.6	1.6
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0.019	0.35	2.05	0.01	0.01	20.5	25	4.6	1.6																			
PROPRIÉTÉS MÉCANIQUES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0.2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>390</td> <td>570</td> <td>35</td> <td colspan="2">70</td> <td>HRC</td> </tr> </tbody> </table>									Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded	390	570	35	70		HRC		
Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness																					
				RT																							
As Welded	390	570	35	70		HRC																					
ETUVAGE	Not required																										
GAS ACC. EN ISO 14175																											



CEWELD SA 904L

SA 904L 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663415431

SA 904L 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663415448