



# CEWELD 904L Tig

TYPE	Solid stainless steel austenitic filler metal with excellent corrosion resistance for Tig welding																		
TOEPASSINGEN	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants																		
EIGENSCHAPPEN	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.																		
CLASSIFICATIE	<table border="0"> <tr> <td>AWS</td> <td>A 5.9: ER385</td> </tr> <tr> <td>EN ISO</td> <td>14343-A: W 20 25 5 Cu L</td> </tr> <tr> <td>W.Nr.</td> <td>1.4539</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	AWS	A 5.9: ER385	EN ISO	14343-A: W 20 25 5 Cu L	W.Nr.	1.4539	F-nr	6	FM	5								
AWS	A 5.9: ER385																		
EN ISO	14343-A: W 20 25 5 Cu L																		
W.Nr.	1.4539																		
F-nr	6																		
FM	5																		
GESCHIKT VOOR	<p>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</p> <p>X1CrNiMoN25-25-2, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X2NiCrMoCuN25-20-5, X2NiCrMoCuN20-18, X4NiCrMoCuNb 20-18-2, X5NiCrMoCuTi20-18, X5NiCrMoCuNb22-18</p> <p>ASTM A182, UNS N08904, S31726 Uranus B6, 904L, Z2NCDU25-20,</p>																		
GOEDKEURINGEN	CE																		
LASPOSITIES																			
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</td> <td>0.01</td> <td>0.01</td> <td>20</td> <td>25</td> <td>4.5</td> <td>1.6</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	0.019	0.35	2	0.01	0.01	20	25	4.5	1.6
C	Si	Mn	P	S	Cr	Ni	Mo	Cu											
0.019	0.35	2	0.01	0.01	20	25	4.5	1.6											
MECHANISCHE WAARDEN	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0.2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</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>410</td> <td>600</td> <td>35</td> <td colspan="2">120</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded	410	600	35	120		HRc		
Heat Treatment	R <sub>P0.2</sub> (MPa)					R <sub>m</sub> (MPa)	A <sub>5</sub> (%)		Impact Energy (J) ISO-V		Hardness								
		RT																	
As Welded	410	600	35	120		HRc													
HERDROGEN	Not required																		
GAS ACC. EN ISO 14175	I1																		



# CEWELD 904L Tig

904L TIG 1,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415349

904L TIG 1,6 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415356

904L TIG 2,0 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415363

904L TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415370

904L TIG 3,2 X 1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663415387