



Inox 385 (AC/DC+)

STAINLESS STEEL

DESCRIPTION

Rutile-basic coated electrode for welding fully austenitic **highly corrosion resistant** stainless steels as 904L, B6. Good weldability in all positions, except vertical down, stable arc, good slag removal, regular finely rippled weld beads. Due to its alloy composition, high Mo-content and Cu, the weld metal is suited against attacks by phosphoric- and sulphuric acids, it shows a high resistance against pitting and stress corrosion in chloride containing media. It is used at operation temperatures up to 400°C.

CLASSIFICATION

AWS A5.4: E385-16 EN 1600 : E 20 25 5 Cu N L R 1 2 ISO 3581-A : E 20 25 5 Cu N L R 1 2

TYPICAL APPLICATIONS

Pulp and paper industry, transport containers, installations of the chemical industry.

BASE MATERIALS

UNS	Alloy	EN	Material N°	CLI
S31703	317 L	X2CrNiMo18-15-4	1.4438	
	317 LNM	X2CrNiMoN17-13-5	1.4439	
		G-X7NiCrMoCuNb 25-20	1.4500	
		X5CrNiMoCuTi 20-18	1.4506	
N08904	904L	X1NiCrMoCu25-20-5	1.4539	URB6(N)

PROCEDURE

Rebaking 2-3 hours at 250-300°C. Interpass temperature : < 150°C.

MECHANICAL PROPERTIES

Tensile strength: > 82 671 psi (> 570 MPa)
 Yield strength: > 53 663 psi (> 370 MPa)
 Elongation: > 35 %
 Impact (Charpy V): > 70 J at +20°C

TYPICAL WELD METAL COMPOSITION (%)

C	Mn	Si	Cr	Ni	Mo	Cu
<0.03	1.4	0.8	20.5	25.0	4.5	1.5

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") 2.5 mm (3/32")
 Amperage: 90-130 A 70-100 A 50-70 A

WELDING POSITIONS



1G/PA

2F/PB

2G/PC

3G/PF

4G/PE

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