



MIG 27/31CU

Classification

AWS A5.9 : ER383

ISO 14343-A : G 27 31 4 Cu L

Description & Applications

Very low carbon content solid wire for GMAW of totally austenitic stainless steels like Ur B28™*, Sanicro 28*. Very good resistance to attacks by phosphoric and sulphuric acids. High resistance against pitting and stress corrosion in chloride containing media.

* Sanicro is a trade name of Sandvik, Ur 28™ is a trade name of Creusot Loire Industries

Main applications: Chemical and petrochemical industries.

Base materials :

Fully austenitic stainless steel :

UNS	Alloy	EN 10088	Material N°
N08904	904L	X1NiCrMoCu25-20-5	1.4539
N08028	28	X1NiCrMoCu31-27-4	1.4563

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co
Min			1.0	26.5	30.0	3.2	0.70	-			-
Max	0.025	0.50	2.5	28.5	33.0	4.2	1.50	-	0.02	0.02	-
Type	0.010	0.15	1.8	27.0	31.0	3.5	1.0	0.01	0.015	0.01	0.05

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	240	520	30	-
Max				-
Type	350	550	35	+20°C 100

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: M12 (Ar+0.5-5%CO ₂) M13 (Ar+0.5-3%O ₂) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

Back shielding with Argon or Nitrogen gas or with copper backing support to avoid "back end" rust phenomena.

FT En-MN25-191118

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