TIG 20/25CU

Old reference: TIG 385

Classification

AWS A5.9 : ER385 ISO 14343-A : W 20 25 5 Cu L

Description & Applications

Low carbon content solid rod for GTAW of totally austenitic stainless steels like Ur B6™, 904L…. Very good resistance to attacks by organic, phosphoric and sulphuric acids. High resistance against pitting and stress corrosion in chloride containing media.

Main applications: Petrochemical and chemical industries, pulp and paper industry.

Base material:

Fully austenitic stainless steel :

UNS	*Alloy*	*EN 10088*	*Material N°*
N08904	904L	X1NiCrMoCu25-20-5	1.4539

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	P	S	Co
Min			1.0	19.5	24.0	4.2	1.2	-			-
Max	0.025	0.50	2.5	21.5	26.0	5.2	2.0	-	0.02	0.02	-
Type	0.010	0.40	1.8	20.0	25.0	4.5	1.5	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	320	520	30	-	-
Max					
Type	350	550	36	+20°C -196°C	120 80

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 l/min Back shielding: I1 (Ar) / N1 (Nitrogen) : 3-6 l/min

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

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