CEWELD AA 904L

certilas® THE FILLER METAL SPECIALIST

TYPE	Rutile fluxcored austenitic filler metal with excelent corrosion resistance
ANWENDUNGEN	Tanks and process vessels, piping systems, agitators, rotors, cast pumps and valves for use in fertilizer, phosphoric-, sulphuric-, acetic- and acid environments.
EIGENSCHAFTEN	The Ceweld AA 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 fluxcored wire 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. Suitable only in down-hand positions.

KLASSIFIKATION

AWS	A 5.22: ~385T0-4
EN ISO	17633-A: T Z 20 25 5 Cu N L R M21 3
W.Nr.	1.4539
F-nr	5
FM	6

GEEIGNET FÜR

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,

ZULASSUNGEN: CE

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)

C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu
0.035	0.5	3.5	0.02	0.002	20	25.5	4.5	0.072	1.6

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				-196°C	
As Welded	430	640	32	35	HRc

RÜCKTROCKNUNG: Not required

GAS ACC. EN ISO 14175: M21

CEWELD AA 904L

AA 904L 1.2MM

Packaging	KG/unit	EanCode
BS-300	15	8720682050279