



CEWELD 904L Tig

TYPE	Solid stainless steel austenitic filler metal with excelent corrosion resistance for Tig welding								
APPLICATIONS	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric,sulphuric and acetic acid plants								
PROPERTIES	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.								
CLASSIFICATION	AWS	A 5.9: ER385							
	EN ISO	14343-A: W 20 25 5 Cu L							
	W.Nr.	1.4539							
	F-nr	6							
	FM	5							
SUITABLE FOR	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,								
APPROVALS	CE								
WELDING POSITIONS	 PA PB PC PD PE PF PG								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	P	S	Cr	Ni	Mo	Cu
	0.019	0.35	2	0.01	0.01	20	25	4.5	1.6
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness	
					RT				
	As Welded	410	600	35	120			HRc	
REDRYING	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