CEWELD AA 904 LP

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile fluxcored austenitic filler metal with excelent corrosion resistance

APPLICATIONS

Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric,sulphuric and acetic acid plants

PROPRIÉTÉS

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 for all positions.

CLASSIFICATION

AWS	A 5.22: ~385T1-4
EN ISO	17633-A: T 20 25 5 Cu N L P M21 2
W.Nr.	1.4539
F-nr	6
FM	5

CONVIENT POUR

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,

AGRÉMENTS

CE

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	P	Cr	Ni	Mo	N	Cu
0.03	0.65	1.55	0.025	21	25.5	5	0.15	1.35

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -196°C	Hardness
As Welded	425	665	35	60	HRc

ETUVAGE

140°C / 24 hr

GAS ACC. EN ISO 14175

M21

CEWELD AA 904 LP

AA 904 LP 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413734