



CEWELD ER 383

TYPE	ER 385 Stainless steel Mag welding wire for the GMAW process									
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	ER 383 is used to weld base metals of similar composition to itself or to other grades of stainless steel. ER383 contains a low maximum of carbon, silicon, and sulfur to decrease the hot cracking and fissuring, while maintaining the resistance to corrosion.									
CLASSIFICATION	AWS	A 5.9: ER383								
	EN ISO	14343-A: G 27 31 4 Cu L								
	W.Nr.	1.4563								
	F-nr	6								
	FM	5								
CONVIENT POUR	Alloy 825 N08825 , Alloy 825 h Mo N08821, Alloy 28 and Alloy 20 (X1NiCrMoCu31-27-4), Alloy 904L (X1NiCrMoCu25-20-5), 1.4563, 1.4539, NiCr 21 Mo 2.4858, NiCr 21 Mo 6Cu 2.6410, X3NiCrCuMoTi27-23 1.4503									
AGRÉMENTS	CE									
POSITIONS DE SOUDAGE	PAPBPC									
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu
	0.02	0.4	1.55	0.017	0.01	28.2	32.1	3.9	0.05	0.95
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V				Hardness	
	As Welded	380	570	38	RT				HRc	
					100					
ETUVAGE	Not required									
GAS ACC. EN ISO 14175	I1, M21, I3									