



# CEWELD 904L

TYPE	Stainless steel welding wire 904L with excellent 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																
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	<table><tr><td>AWS</td><td>A 5.9: ER385</td></tr><tr><td>EN ISO</td><td>14343-A: G 20 25 5 Cu L</td></tr><tr><td>W.Nr.</td><td>1.4539</td></tr><tr><td>F-nr</td><td>6</td></tr><tr><td>FM</td><td>5</td></tr></table>							AWS	A 5.9: ER385	EN ISO	14343-A: G 20 25 5 Cu L	W.Nr.	1.4539	F-nr	6	FM	5
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EN ISO	14343-A: G 20 25 5 Cu L																
W.Nr.	1.4539																
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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																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	C	Si	Mn	Cr	Ni	Mo	Cu										
	0.019	0.35	2	20.5	25	4.6	1.6										
MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness										
	As Welded	380	560	35	RT		HRc										
REDRYING	Not required																
GAS ACC. EN ISO 14175	M13, M12																



# CEWELD 904L

904L 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415400

904L 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415417

904L 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663415424