









CEWELD 904L

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|---|---|-------------------------|----------------------|--------------------|-------------------------|-----|----------|
| 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 he 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: G 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 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PE</div> <div> PF</div> | | | | | | |
| 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 _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
| | | | | | RT | | |
| | As Welded | 380 | 560 | 35 | 70 | | HRc |
| REDRYING | Not required | | | | | | |
| GAS ACC. EN ISO 14175 | M13, M12 | | | | | | |



CEWELD 904L

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|------------|-----------|---------|---------------|
| 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 |