DAIKOSTRIP 385

SAW - ESW

PRODUCT DESCRIPTION

Cu alloyed Cr-Ni-Mo strip electrode to deposit corrosion resistant alloy of 20%Cr/25%Ni/5%Mo/Cu composition.
It is used for weld surfacing of components in the chemical, petrochemical, marine industry where corrosion resistance equal to UNS N08904 is required. Typical components are heat exchangers, pressure vessels, shafts etc. The resistance to pitting corrosion is better than for 317L. Good resistance to stress corrosion cracking and to intergranular corrosion.The resistance to intergranular corrosion is good. In constructions that have to be post-weld heat treated for longer periods DAIKOSTRIP 309L/LMo should be used for the first layer and the heat treatment should be carried out before welding the subsequent layer(s).The micro structure of the weld overlay is fully austenitic.

SPECIFICATIONS

AWS A5.9	EQ385
EN ISO 14343-A	B 20 25 5 Cu L
DIN	-
Approvals	-
Shielding	DAIKOFLUX 930, 937AS

ASME IX QUALIFICATION		FERRITE	PREN	HARDNESS
F-No (QW432)	6	-	35	-
A-No (QW442)	-			

Chemical composition (nominal)

Chemical composition of the strip (nominal) %

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
<0.020	0.4	1.8	0.015	0.015	20.0	25.0	4.5	1.5

Chemical composition of weld deposit wt%

	Type of overlay	C	Cr	Ni	Mo	Cu
SAW **3 layers DAIKOSTRIP 385**	904L, E385	<0,03	19,5-20,5	24-25	4,2-4,5	1,2-1,6
SAW **1 layer DAIKOSTRIP 309LMo** **2 layers DAIKOSTRIP 385**	904L, E385	≤0,03	19,5-20,5	23,5-24,5	4-4,5	1,2-1,5
ESW **3 layers DAIKOSTRIP 385**	904L	<0,02	19-20	24-25	4,2-4,5	1,2-1,6
1 layer DAIKOSTRIP 309LMo **2 layers DAIKOSTRIP 385**	904L	<0,02	19-20	24-25	4,2-4,5	1,2-1,6