



# DAIKOWM 385



SUPERAUSTENITIC STEELS  
904L

## DESCRIPTION

Solid wire to match fully austenitic alloy 904L

Corrosion-resistant, chromium-nickel-molybdenum-copper solid wire rod for welding austenitic stainless alloys of the 20% Cr, 25% Ni, 5% Mo, 1.5% Cu, low C types. Its weld metal has good resistance to stress corrosion and intergranular corrosion and shows very good resistance to attack in non-oxidising acids. The resistance to crevice corrosion is better than that of ordinary 18% Cr, 8% Ni, Mo steels. The alloy is widely used in many applications related to the process industry.

## SPECIFICATIONS

EN ISO 14343-A	G 20 25 5 Cu L	AWS A5.9	ER385
Shielding	M12, M13	Positions	PA, PB, PC, PD, PE, PF, PG
Current	DC+	Packaging Type	Drums, B300, D200 and D100 spools.

## ASME QUALIFICATIONS

		PREN
F-No (QW432)	6	34.19
A-No (QW442)	-	

CHEM. COMP. %	DEFAULT	MECHANICAL PROPERTIES	MIN. PER STANDARD	PRODUCT
C	0.01	Tensile strength $R_m$ MPa	510	650
Mn	1.65	Yield strength $R_{p0.2}$ MPa	320	490
Ni	25	Elongation A ( $L_0=5d_0$ ) %	25	35
Cr	20	Impact Charpy ISO-V	-	200J @ 20°C
P	0.015	Impact Charpy ISO-V	-	-
S	0.01			
Mo	4.3			
Si	0.35			
Cu	1.45			
		<b>WELDING PARAMETERS</b>	1.0 mm	1.2 mm
		Ampere	160A - 280A	240A - 300A
		Voltage	18V - 27V	31V - 35V
		Packaging	Ø 0,8÷1,6mm	Ø 0,8÷1,6mm
		Packaging Type	Drums, B300, D200 and D100 spools.	Drums, B300, D200 and D100 spools.



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# 904L

DESCRIPTION

SUPERAUSTENITIC STEELS

904L

## APPLICATION

This consumable is designed to provide a fully austenitic low-carbon weld metal, enriched with molybdenum and copper. It is renowned for its excellent corrosion resistance in acidic environments, such as sulfuric and phosphoric, as well as in other types of both inorganic and organic acids. However, it is not the ideal choice for environments with concentrated nitric acid. For applications requiring chloride pitting resistance, the use of nickel-based over-alloyed weld metals, such as Alloy 625, is recommended. It is the preferred weld metal for certain low-alloy austenitics, such as Creusot UHB 34L and UHB 734L, especially when used with wet-process phosphoric acid. Typical applications include tanks and process vessels, piping systems, agitators, and rotors, as well as cast pumps and valves used for the production of fertilizers, phosphoric, sulfuric, and acetic acid. It is also suitable for brackish and marine environments and in some offshore applications, such as overlays on mild and low-alloy steels. No preheat or post-weld heat treatment (PWHT) is necessary; however, it is essential to control the interpass temperature up to a maximum of 150 °C, paying particular attention to the heat input, especially when using large diameter SMAW electrodes.

## ALLOY TYPE

904L is a nominally 20%Cr-25%Ni-5%Mo-2%Cu alloy with good corrosion resistance.

## MICROSTRUCTURE

In the as-welded condition the weld metal microstructure is fully austenitic.

## MATERIALS

Suitable for copper-free variants of the listed alloys and also to overmatch leaner alloys such as 317L, 317LN, 317LM, 317LMN, 1.4439, 1.4440 and 531726.

**EN W.Nr.:** 1.4505 (X4NiCrMoCuNb20-18-2), 1.4506 (X5NiCrMoCuTi 20-18), 1.4536 (GX2NiCrMoCuN25-20), 1.4539 (X1CrNiMoCuN25-20-5), 1.4585 (G-X7CrNiMoCuNb1818), 1.4500 (G-X7NiCrMoCuNb2520)

**ASTM:** N08904

**PROPRIETARY:** Uddelholm 904L (voestalpine), 2RK65 (Sandvik), Cronifer 1925LC (VDM), 254SLX (Outokumpu), Uranus® B6, B6M (Industeel)

