




CEWELD 904L

TYPE	Solid stainless steel austenitic filler metal with excellent corrosion resistance						
ANWENDUNGEN	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants						
EIGENSCHAFTEN	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.						
KLASSIFIKATION	AWS	A 5.9: ER385					
	EN ISO	14343-A: G 20 25 5 Cu L					
	W.Nr.	1.4539					
	F-nr	6					
	FM	5					
GEEIGNET FÜR	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,						
ZULASSUNGEN	CE						
SCHWEISSPOSITIONEN							
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
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
	As Welded	380	560	35	RT		HRC
					70		
RÜCKTROCKNUNG	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