

# ER 385 (904L)

Stainless Steel WIRE/GTAW

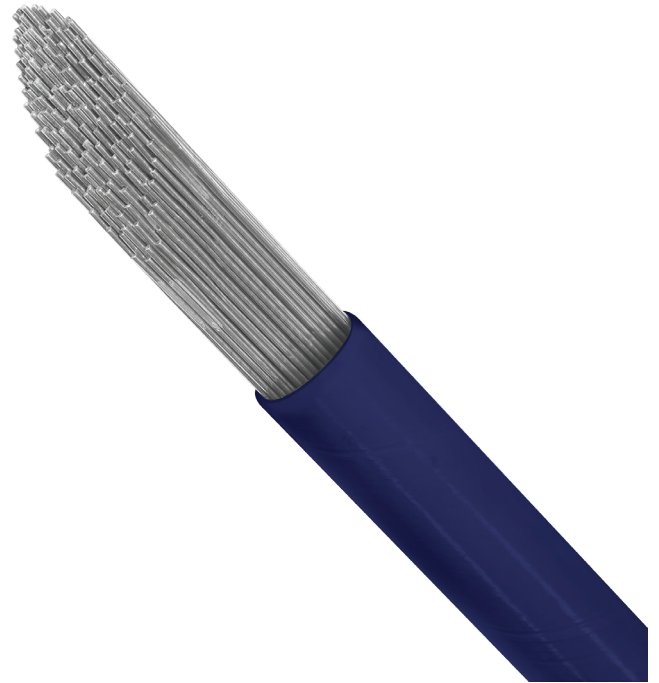
## Standards

EN/ISO-Standard - 14343-A  
EN/ISO-Classification - W 20 25 5 Cu L

AWS-Standard - A5.9  
AWS-Classification - ER 385

## Features and Applications

- Super austenitic stainless steel wire characterised by its high resistance to stress corrosion cracking.
- High Ni content in conjunction with the addition of Cu also results in excellent resistance in sulphuric solutions.
- Ideal for environments subject to pitting and crevice corrosion attacks.
- The microstructure is fully austenitic and is less sensitive to ferrite and sigma phase precipitation than conventional grades with high molybdenum contents.
- Typically used in the phosphoric acid and chemical fertiliser industries, hydrometallurgy, paper industry and applications subject to seawater etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

UNS N08904, ASTM B625, B673, B674, B677\*

\* Illustrative, not exhaustive list

## Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

## Shielding Gases

EN ISO 14175 - TIG: I1 (Argon)

## Polarity

DC (-)

## Mechanical Properties

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)
≥510	≥320	≥25	-

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

## Chemical Composition % (Typical)

C %	Mn %	Si %	S %	P %	Ni %	Cr %	Mo %	Cu %
<0.025	1.72	<0.50	<0.020	<0.020	24.87	19.79	4.34	1.36

## Packaging Data

Part No.	Diameter Ø (mm)	Package Length (mm)	Package Weight (Kg)	Package Type
6011100593	1.60	1000	5	Cardboard Tube
6011100594	2.40	1000	5	Cardboard Tube
6011100595	3.20	1000	5	Cardboard Tube

**Liability:** Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

