

Stainless solid wire

Classification

AWS A 5.9-93	: ER385
EN 12072-99	: W 20 25 5 Cu L / G 20 25 5 Cu L

General description

Solid wire for welding of fully austenitic steels of type 20%Cr / 25%Ni / 4.5%Mo / 1.5%Cu
Highly corrosion resistant in sulphuric and phosphoric acid

Shielding gases (acc. EN 439)

GTAW	I1	Inert gas Ar (100%)
GMAW	M12	Mixed gas Ar+ >0-5% CO ₂
GMAW	M13	Mixed gas Ar+ >0-3% O ₂

Approvals

	TÜV
GTAW	+
GMAW	+

Chemical composition (w%), typical, wire / rod

C	Mn	Si	Cr	Ni	Mo	Cu
0.009	1.7	0.3	20	25	4.4	1.5

Mechanical properties, typical, all weld metal

	Process	Shielding gas	Condition	0.2% Proof strength	Tensile strength	Elongation	Impact ISO-V(J)	
				(N/mm ²)	(N/mm ²)	(%)	+20°C	-196°C
Typical values	GTAW	I1	AW	380	560	35	80	
	GMAW	M12	AW	350	610	35	100	

Materials to be welded

Steel grades	EN 10088-1/-2	EN 102 13-4	W.Nr.
Fully austenitic NiCrMoCu- and CrNiMoCu-steels	X5 NiCrMoCuTi 20 18	GX7 NiCrMoCuNb 25-20	1.4500
		G-X2 NiCrMoCuN 20 18	1.4531
		G-X2 NiCrMoCuN 25 20	1.4536
		X1 NiCrMoCuN 25 20 5	1.4539
		G-X7 CrNiMoCuNb 18 18	1.4585
	X5 NiCrMoCuNb 22 18		1.4586

Packaging

Process	Unit	Sizes (mm)						
		0.8	1.0	1.2	1.6	2.0	2.4	
GTAW	2 and 5 kg tube				X	X	X	
GMAW	15 kg spool BS300	X	X	X				

Other sizes and packaging on request