ES TIG 385

GTAW

ER385

ESWECO
The Art of Welding

Description

Bare, corrosion-resistant welding rods for welding austenitic stainless steels of the 20Cr-25Ni-4.5Mo-1.5Cu type. The 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 pitting and crevice corrosion is better than that of ordinary 18Cr-8Ni-Mo steels.

ES TIG 385 is typically used in the chemical industry, sea water, pharmaceuticals applications, pulp and paper industries, Used in fabrication of equipment and vessels for handling and storage of sulfuric acid and phosphoric acid

Current

DC (-)

Classifications

EN 12072	W 20 25 5 CuL
SFA/AWS A5.9	ER385

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	<0.5	1.8	20.5	25.0	4.7	1.6

Typical mech. Properties all weld metal

Yield stress, MPa	340
Tensile strength, MPa	540
Elongation, %	37

Charpy V

Test temps, °C	Impact values, J
+20	120

Welding parameters

Diameter,mm	Length, mm	Weight of rods/box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0