



CEWELD SA 904L

TYPE

ANWENDUNGEN

EIGENSCHAFTEN

KLASSIFIKATION

GEEIGNET FÜR

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

MECHANISCHE GÜTEWERTE

RÜCKTROCKNUNG

GAS ACC. EN ISO 14175

SAW stainless steel austenitic filler metal with excelent corrosion resistance

Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants

SA 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. Fluxes to be used with our fused flux FL 880 or agglomerated flux FL 838.

AWS

EN ISO

W.Nr.

F-nr

FM

A 5.9: ER385

14343-A: S 20 25 5 Cu L

1.4539

6

5

1.4539 / 904L CrNiMoCu / 20 25 5 Cu L

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

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, AISI 904L, Z2NCDU25-20,

CE

PA

PB

PC

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.019	0.35	2.05	0.01	0.01	20.5	25	4.6	1.6

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	390	570	35	70		HRc

Not required



CEWELD SA 904L

SA 904L 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663415431

SA 904L 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663415448