



CEWELD ER 383

TYPE	ER 385 Stainless steel Mag welding wire for the GMAW process									
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	ER 383 is used to weld base metals of similar composition to itself or to other grades of stainless steel. ER383 contains a low maximum of carbon, silicon, and sulfur to decrease the hot cracking and fissuring, while maintaining the resistance to corrosion.									
KLASSIFIKATION	AWS	A 5.9: ER383								
	EN ISO	14343-A: G 27 31 4 Cu L								
	W.Nr.	1.4563								
	F-nr	6								
	FM	5								
GEEIGNET FÜR	Alloy 825 N08825 , Alloy 825 h Mo N08821, Alloy 28 and Alloy 20 (X1NiCrMoCu31-27-4), Alloy 904L (X1NiCrMoCu25-20-5), 1.4563, 1.4539, NiCr 21 Mo 2.4858, NiCr 21 Mo 6Cu 2.6410, X3NiCrCuMoTi27-23 1.4503									
ZULASSUNGEN	CE									
SCHWEISSPOSITIONEN	 PA  PB  PC									
TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)	C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu
	0.02	0.4	1.55	0.017	0.01	28.2	32.1	3.9	0.05	0.95
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V				Hardness	
	As Welded	380	570	38	RT				HRc	
	As Welded	380	570	38	100				HRc	
RÜCKTROCKNUNG	Not required									
GAS ACC. EN ISO 14175	I1, M21, I3									