



CEWELD AA 904 LP

TYPE	Rutile fluxcored austenitic filler metal with excelent corrosion resistance								
APPLICATIONS	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric,sulphuric and acetic acid plants								
PROPRIÉTÉS	The Ceweld AA 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 fluxcored wire 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. Suitable for all positions.								
CLASSIFICATION	AWS	A 5.22: ~385T1-4							
	EN ISO	17633-A: T 20 25 5 Cu N L P M21 2							
	W.Nr.	1.4539							
	F-nr	6							
	FM	5							
CONVIENT POUR	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,								
AGRÉMENTS	CE								
POSITIONS DE SOUDAGE									
ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)	C	Si	Mn	P	Cr	Ni	Mo	N	Cu
	0.03	0.65	1.55	0.025	21	25.5	5	0.15	1.35
PROPRIÉTÉS MÉCANIQUES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness	
					-196°C				
	As Welded	425	665	35	60			HRc	
ETUVAGE	140°C / 24 hr								
GAS ACC. EN ISO 14175	M21								



CEWELD AA 904 LP

AA 904 LP 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413734