



# Product Data Sheet

W 'Tungsten inert gas arc welding'

# OK Tigrod 385

Signed by Mats Linde	Approved by Per-Åke Pettersson/Christos Skodras	Reg no EN005044	Cancelling EN004166	Reg date 2009-11-24	Page 1 (1)
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## REASON FOR ISSUE

Shielding Gas standard up date.

## GENERAL

Bare corrosion resisting welding rods for welding of austenitic stainless steels of type 20Cr-25Ni-4.5Mo-1.5Cu. The weld metal has a good resistance to stress corrosion and intergranular corrosion and shows a very good resistance to attack in nonoxidizing acids. The resistance to pitting and crevice corrosion is better than for ordinary 18Cr-8Ni-Mo-steels.

**Shielding Gas:** I1, I2, I3 (EN ISO 14175)

**Alloy Type:** Fully austenitic (20 % Cr - 25 % Ni - 5 % Mo - 1.5 % Cu - Low C)

## CLASSIFICATIONS Wire Electrode

EN ISO 14343      W 20 25 5 CuL  
SFA/AWS A5.9      ER385

## APPROVALS

VdTÜV              05444 (IT)

## CHEMICAL COMPOSITION

	Wire/Strip (%)	
	Min	Max
C		0.025
Si		0.50
Mn	1.4	2.2
P		0.020
S		0.020
Cr	19.5	21.5
Ni	24.0	26.0
Mo	4.2	5.2
Cu	1.2	2.0
Others tot		0.50

## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	As welded	
	Min	Typ
Rp0.2 (MPa)	320	340
Rm (MPa)	510	540
A4-A5 (%)	25	37
Charpy V at 20°C (J)		120

## OTHER DATA

Welding should proceed with low heat input (general recommendation max 1.5 kJ/mm).