GWELD
SEAL OF TRUST

GETIG 904L

IDENTIFICATION
Getig 904L, ER 385

CLASSIFICATION
AWS/SFA-5.9 ER 385 BS 2901-90 904S92
DIN 8556 WSGX2CrNiMoCuN 20.25

DESCRIPTION

Solid wire which gives a “904L” type fully austenitic deposit. The wire gives a low carbon nil ferrite “super- austenitic” weld metal with good resistance to attack by a range of organic and inorganic acids, and better resistance to pitting attack than 317L type.

CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.025 max	1.0 - 2.50	0.25 - 0.65	0.015 max	0.015 max	19.5 - 21.5	24 - 26	4.20 - 5.20	1.2 - 2.0

MECHANICAL PROPERTIES (RANGE)

TS (N/mm²)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
660 min	40 min	-196°C	50

TYPICAL APPLICATIONS

- Corrosion resistance steels of the “904L” type ASTM UNS N08094 DIN 1.4500 (Cast), 1.4539.
- Widely used in chemical process plant, particularly in phosphoric and Sulphuric acid, fertilizer and acetic acid production.

CORROSION RESISTANCE

Very good resistance to general and intergranular corrosion in non-oxidating acid environments e.g. Sulphuric upto 90%, phosphoric and organic acids. Good resistance to stress corrosion cracking and pitting corrosion in chloride bearing environments.

SHIELDING GAS : Pure Argon 99.9% 6-12 l/mn.

WELDING CURRENT : DC (-)

SCALING TEMPERATURE : Approximately 1000°C in air

PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Packet (kg)	Packing / Box (kg)

1.6	1000	5	5 x 4 = 20
2	1000	5	5 x 4 = 20
2.40 / 2.50	1000	5	5 x 4 = 20
3.15 / 3.20	1000	5	5 x 4 = 20