

20.25.4.Cu

SOLID WIRES FOR TIG AND MIG FOR ALLOY 904L

PRODUCT DESCRIPTION

Solid wire for TIG and MIG welding.

SPECIFICATIONS

AWS A5.9M	ER385
BS EN ISO 14343-A	20 25 5 Cu L
BS EN ISO 14343-B	SS385

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 9

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min.	--	1.0	0.25	--	--	19.5	24.0	4.2	1.2
Max.	0.025	2.5	0.50	0.015	0.020	21.5	26.0	5.2	2.0
Typical	0.01	1.7	0.3	0.001	0.015	20	25	4.5	1.5

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded	TIG
Tensile strength (MPa)	650
0.2% proof strength (MPa)	490
Elongation (%) 4d	35
5d	32
Impact ISO-V(J) +20°C	210
Hardness cap/mid HV	175/195

TYPICAL OPERATING PARAMETERS

	Shielding	Current	Diameter (mm)	Voltage
TIG	Argon*	DC-	2.4	100A, 12V
MIG	Ar+2%O ₂ **	DC+	1.2	230A, 30V

* Also required as a purge for root runs.

** Ar-He-CO₂ proprietary mixtures also suitable.

PACKAGING DATA

Diameter (mm)	0.8	1.2	1.6	2.0	2.4
TIG		--	2.5kg tube	2.5kg tube	2.5kg tube
MIG	15kg spool	15kg spool	--	--	--

FUME DATA

MIG fume composition (wt %) [TIG fume negligible]

Fe	Mn	C ⁹	Ni	Mo	Cu	OES (mg/m ³)
28	13	16	20	3	2.5	2.5