

OK Autrod 385

A continuous solid corrosion resisting chromium-nickel-molybdenum-copper wire for welding of austenitic stainless alloys of 20% Cr, 25% Ni, 5% Mo, 1.5% Cu, low C types. OK Autrod 385 weld metal has a good resistance to stress corrosion and intergranular corrosion and shows a very good resistance to attack in non-oxidizing acids. The resistance and crevice corrosion is better than for ordinary 18% Cr, 8% Ni, Mo steels. The alloy is widely used in many applications related to the process industry. OK Autrod 385 can be used in combination with OK Flux 10.93.

Specifications

Classifications	EN ISO 14343-A : S 20 25 5 Cu L SFA/AWS A5.9 : ER385
Approvals	VdTÜV : 12101

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Fully austenitic (20 % Cr - 25 % Ni - 5 % Mo - 1.5 % Cu - Low C)
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Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	N
0.01	1.7	0.4	25.0	20.0	4.4	1.5	0.05