

OK Tigrod 385

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.

Specifications

Classifications	EN ISO 14343-A : W 20 25 5 Cu L SFA/AWS A5.9 : ER385
Approvals	VdTÜV : 05444

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	340 MPa (49 ksi)	540 MPa (78 ksi)	37 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	120 J (88.5 ft-lb)

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