

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.

Specifications

Classifications	EN ISO 14343-A : G 20 25 5 Cu L SFA/AWS A5.9 : ER385
Approvals	NAKS/HAKC : 1.2 mm

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, M13 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	340 MPa	540 MPa	37 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	20 °C	120 J

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

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h

Welding Parameters

Amps	Wire Diameter	Volts
230-350 A	1.6 mm	24-28 V
230-350 A	1.6 mm	24-28 V