# OK Autrod 385

A continous 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<br>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) |

| 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 | | |
|---|---|---|
| **Condition** | **Testing Temperature** | **Impact Value** |
| As Welded | 20 °C ( 68 °F ) | 120 J ( 89 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 |

| Deposition Data | | | | |
|---|---|---|---|---|
| **Diameter** | **Current** | **Voltage** | **Wire Feed Speed** | **Deposition Rate** |
| 1.2 mm<br>( 0.047 in. ) | 100-300 A | 15-29 V | 3.0-14.0 m/min<br>( 118-551 in./min ) | 1.6-7.5 kg/h<br>( 3.5-16. lbs/h ) |

| Recommended Welding Parameters | | |
|---|---|---|
| **Current** | **Wire Diameter** | **Voltage** |
| 230-350 A | 1.6 mm ( 1/16 in. ) | 24-28 V |
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