

Exaton 385

385 welding wire is suitable for joining steels of the 20Cr/25Ni/4.5Mo/1.5Cu type - for example 904L used in many areas of the process industry, such as in the production of acetic acid, sulfuric acid, terephthalic or tartaric acid and vinyl chloride. It is also suitable for use in cooling operations involving sea water or heavily polluted river water. It is used for Submerged Arc Welding.

Specifications	
Classifications	EN ISO 14343-A : S 20 25 5 Cu L SFA/AWS A5.9 : ER385 Werkstoffnummer : ~1.4519
Approvals	CE : EN 13479 UKCA : EN 13479

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

Typical Wire Composition %								
C	Mn	Si	S	P	Ni	Cr	Mo	Cu
<=0.020	1.8	0.4	<=0.015	<=0.015	25	20	4.5	1.5