

OK Tigrod 385

GTAW
W 20 25 5 CuL

Description

Bare, corrosion-resistant welding rods for welding austenitic stainless steels of the 20Cr-25Ni-4.5Mo-1.5Cu type. The weld metal has good resistance to stress corrosion and intergranular corrosion and shows very good resistance to attack in non-oxidising acids. The resistance to pitting and crevice corrosion is better than that of ordinary 18Cr-8Ni-Mo steels.

Welding current

DC(-)

Classifications

EN 12072	W 20 25 5 CuL
SFA/AWS A5.9	ER385

Wire composition

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	<0.5	1.8	20.5	25.0	4.7	1.6

Typical mech. properties all weld metal

Yield stress, MPa	340
Tensile strength, MPa	540
Elongation, %	37

Charpy V

Test temps, °C	Impact values, J
+20	120

Approvals

UDT VdTÜV	DIN 8556
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Packing data

Diameter, mm	Length, mm	Weight of rods/ box, kg
1.6	1000	5.0
2.0	1000	5.0
2.4	1000	5.0
3.2	1000	5.0