Stainless Steel
Solid GMA Welding Wire

TALWELD WELDING ALLOYS

Datasheet SM09

KM-385 (904L)

Classification

Shielding Gas:	Ar+1~2%O_2	AWS A5.9/A5.9M	ER385
	Ar+1~2%CO_2	AS/NZS ISO 14343	B SS385

Applications and Features

(1) Weld metal is austenite structure with 20%Cr-25%Ni-4.7%Mo-1.5%Cu.

(2) Ideal for welding UNS N08904 and other grade stainless steel.

(3) It is suitable for welding chemical vessels, such as ASTM B625, B673, B674 and B677 steel.

Welding Instruction

(1) Use Ar blend with 1~2%O_2 for high current, spray transfer welding .

(2) Use Ar blend with 1~2%CO_2 for low current, short-circuit transfer welding.

Typical Chemical Composition Wire (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.020	0.41	1.73	0.010	0.010	20.33	25.05	4.55	1.52

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar+2%O_2)

Tensile Strength MPa	Yield Strength MPa	Elongation %
540	340	37

Size and Suggested Operating Range (DC+)

Shielding Gas		Diameter (mm) 1.2
Ar+1~2%CO_2	Amp	100~210
	Volt	17~22
Ar+1~2%O_2	Amp	200~300
	Volt	24~30

Diam.	15 kg Spool
1.2mm	KM9041215

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