

KT-385 (904L)

Classification

AWS A5.9/A5.9M

ER385

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.

Typical Chemical Composition (wt%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.019	0.34	1.74	0.009	0.011	20.45	25.14	4.52	1.54

Typical Mechanical Properties of Weld Metal (Shielding Gas : Ar)

Tensile Strength MPa	Yield Strength MPa	Elongation %
545	350	36

Sizes and Suggested Operating Range

Size mm	Current A	Gas Flow L/min	Shielding Gas
16	75- 100	25	Ar
24	150-200	5	Ar

Diam.	5 kg Tube
1.6mm	KT90416
2.4mm	KT90424

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