

AA 904L

CATEGORY FCAW Flux-Cored

TYPE Rutile fluxcored austenitic filler metal with excellent corrosion resistance

APPLICATIONS Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants

PROPERTIES The Ceweld AA 904L is used for welding materials of similar chemical composition which are used for fabrication of equipment and vessels for handling of sulfuric acid and many chloride containing media. This fluxcored wire may also find applications for joining Type 317L material where improved corrosion resistance in specific media is needed. In order to reduce the propensity for fissuring and hot cracking, the low melting constituents such as carbon, silicon, and phosphorus are controlled to lower levels in this alloy.

CLASSIFICATION

AWS	A 5.22: E 385LT0-1/-4*
EN ISO	T Z 20 25 5 Cu L R M 3 (C3)
DIN: W.Nr.	1.4539
DIN	8556: 20 25 5 L Cu

SUITABLE FOR W.Nrs: 1.4500, 1.4505, 1.4506, 1.4531, 1.4536, 1.4539, 1.4573, 1.4585, 1.4586, 4 NS N 08904 1.4539, 1.4537, 1.4519, 1.4505, UNS N08904, S31726, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X4NiCrMoCuNb 20-18-2, Uranus B6

APPROVALS CE approved

WELDING POSITIONS:



ALL WELD METAL WEIGHT %

C	Mn	Si	Cr	Ni	Mo	Cu	N
0.03	1.56	0.66	20.9	25.3	4.8	1.34	0.13

ALL WELD MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-196°C	
as welded	423	694	36			65	

WELDING PARAMETERS / PACKING

Welding Parameters				Packing	
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	25	160	BS-300	15	1080

REDRYING TEMPERATURE 150°C/24hr

GAS ACC. EN ISO 14175: M21