



MIG 385



Standards

AWS 5.9
ER 385

EN ISO 14343-A
G 20 255Cu L

W. Nr.
1.4539

Description & applications

Filler metal in solid wire spools for MIG welding of austenitic stainless with high Molybdenum content type 904L, UB6, 317L or similar. The very high Molybdenum content provides an excellent resistance to localized corrosion (pitting, crevice corrosion) particularly in presence of chlorides. Used in the aggressive environments of chemical and petrochemical industries , sea water exchangers, etc...

Also, this grade exhibits a good resistance to stress corrosion.

Typical chemical composition (%)

Cmax	Mn	Si	Cr	Ni	Mo	S max	P max	Fe	Cu
0.02	1.8	0.4	20.0	25.0	4.5	0.02	0.02	Base	1.5

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
590 MPa	400 MPa	37 %	80 J

Operating parameters

Shielding gas recommendations :

EN ISO 14175 M12 : Argon + 2-3 % CO₂ or Argon + 1-2 % O₂ / 12-18 l/mn

