



# TIG 385



## Standards

AWS 5.9  
**ER 385**

EN ISO 14343-A  
**W20 25 5Cu L**

W. Nr.  
**1.4539**

## Description & applications

Filler metal in solid wire sticks for TIG 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...

In addition, this grade exhibits a good resistance to stress corrosion.

## Typical chemical composition (%)

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

## Typical mechanical properties of all-weld metal

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

## Operating parameters

### Shielding gas recommendations :

EN ISO 14175 II: 100 % Argon – 6-12 l/mn    Root: Argon, Nitrogen : 3-6 l/mn

