

SUBARC 904L



These consumables give a fully austenitic, low carbon weld metal with molybdenum and copper, with good resistance to corrosion in sulphuric, phosphoric and other inorganic and organic acids. They are not normally chosen for resistance to corrosion in concentrated nitric acid. For service in severe chloride pitting media, overmatching nickel-base weld metal is recommended. It is the preferred weld metal for some lower

alloy austenitics such as Creusot UHB 34L and UHB 734L for wet process phosphoric acid service. Applications include tanks and process vessels, piping systems, agitators and rotors and cast pumps and valves for use in the fertiliser, phosphoric, sulphuric and acetic acid plants, and in salt and seawater environments. It is also used on mild and low alloy steels.

CLASSIFICATIONS

AWS	A5.9	ER385
BS	EN 12072	20 25 5 Cu L
DIN	8556	SG-X2CrNiMoCu 20 25 / 1.4519

CHEMICAL ANALYSIS

% Carbon	0.010	% Chromium	20.00
% Manganese	1.700	% Nickel	25.00
% Silicon	0.300	% Molybdenum	4.500
% Sulphur	0.001	% Copper	1.500
% Phosphorus	0.010		

**TYPICAL MECHANICAL PROPERTIES
ALL WELD METAL**

Tensile Strength	660 MPa
0.2% Proof Stress	480 MPa
Elongation on 4d	35%
Impact Energy 20°C	210J

Microstructure
In the as-welded condition the weld metal microstructure is fully austenitic.

* Flux Dependant

PACKING DATA

SAW Wire (DC+)

Diameter (mm)	Current		Item Number	Pack Mass (Kg)
	Amps	Volts		
2.40	300	29	078-180	25
3.20	400	32	078-182	25

The information contained or otherwise referenced herein is presented only as typical without guarantee or warranty, and Afrox expressly disclaims any liability incurred from any reliance thereon. No data is to be construed as recommended for any welding condition or technique not controlled by Afrox.

For more information contact the Afrox Customer Service Centre,
tel: 0860 020202 or e-mail: customer.service@afrox.boc.com
Website: www.afrox.com

