

Specifications:

AWS A5.9
AWS Class ER385
ASME SFA 5.9
UNS N08904

Properties:

Tensile Strength: 86,500 psi
Yield Strength: 59,500 psi
Elongation: 36%

Description:

ER385 (904L) is a filler metal that is best used on base metals of similar composition. This alloy is often used in the making of equipment that handles sulfuric acid and other materials containing chloride. ER385 is a good filler metal to join alloy 317L when higher corrosion resistance is needed. This alloy contains low amounts of the elements, carbon, silicon, sulfur and phosphorus to reduce the hot cracking and fissuring. ER385 is often used in the chemical, pharmaceutical, and paper industries.

Available in multiple sizes and diameters in spool and wire rods.

Chemical Composition (Wt%):

Si	Mn	Cu	Mo	S	Ni	Cr	P	C
0.50	1.0-2.5	1.2-2.0	4.2-5.2	0.03	24.0-26.0	19.5-21.5	0.02	0.025

Note: Single values are maximum unless otherwise noted.

Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.