## **INERTFIL 904L**



# MIG/MAG solid wires-TIG rods Stainless and Heat resistant steels

INERTFIL 904L is a G 20 25 5 Cu L / ER385 type solid MAG welding wire, supplied precision layer wound, depositing a 20Cr25Ni5Mo weld metal. Suitable for use with Ar+2%02 or Ar+0.5...5%CO2 mixed shielding gases.

INERTFIL 904L is used for welding of ASTM 316 or similar steels, when a ferrite-free weld metal is required. Mainly used in cryogenic and non-magnetic applications. The impact strength at low temperatures is excellent. Also used for welding 904L to ASTM 304 and 316.

INERTFIL 904L has a very good corrosion resistance to general, pitting and crevice corrosion as well as stress corrosion cracking.

Classif	ication
EN ISO	14343-A: G 20 25 5 Cu L
AWS	A5.9: ER 385

Approvals	Grade
TÜV	•

### **Chemical analysis (Typical values in %)**

C	Mn	Si	P	S	Cr	Ni	Мо	Cu
0.020	1.9	0.4	≤ 0.020	≤ 0.020	20	25	4.5	1.5

#### **All-weld metal Mechanical Properties**

Heat Treatment	Yield Strength	Tensile Strength	Elongation	Impact Energ	gy ISO - V (J)
neat Heatillellt	(MPa)	(MPa)	A5 (%)	+20 °C	-196 °C
As Welded	≥ 410	≥ 560	≥ 35	≥ 80	≥ 32

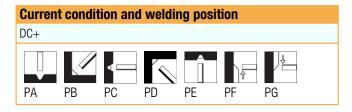
Gas test: 81% Ar + 18% He + 1% CO2

**Shielding Gas -** EN ISO 14175: M12, M13

#### **Materials**

URANUS B6; AISI 904L; 1.4539 (X1NiCrMoCu25-20-5); 1.4439 (X2CrNiMoN17-13-5);

Storage	
Keep dry and avoid condensation	



#### **Packaging data**

Packaging Type	BS300		
Diam(mm) / weight(kg)	15		
1.0	•		
1.2	•		

