

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%O₂ 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.

Classification	
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	Mo	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 (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				+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

Current condition and welding position						
DC+						
						
PA	PB	PC	PD	PE	PF	PG

Packaging data

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