

INERTROD 904L is a W 20 25 5 Cu L / ER385 type solid TIG welding rod depositing a 20Cr25Ni5Mo weld metal. Suitable for use mainly with Ar shielding gas.

INERTROD 904L is used for the 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 toughness at low temperatures is excellent. Also used for welding 904L to ASTM 304 and 316.

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

### Classification

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

### 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: 100% Ar

**Shielding Gas** - EN ISO 14175 : I1

### Materials

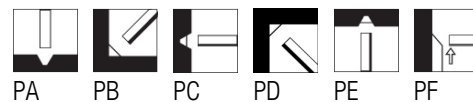
URANUS B6; AISI 904L; 1.4539 (X1NiCrMoCu25-20-5); 1.4439 (X2CrNiMoN17-13-5); 1.4519

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



### Packaging data

Diam. (mm)	Packaging Type	Weight (kg)	Code
1.6	TUB	5	●
2.0	TUB	5	●
2.4	TUB	5	●