

SUPRANOX 904L is a rutile coated MMA electrode for welding identical or similar alloys, with high corrosion-resistance in reducing media, such as sulphuric and phosphoric acids. The weld metal microstructure is austenitic without delta-ferrite. High PREN, increased resistance to pitting and crevice corrosion in water and solutions containing chlorine. Typical applications in the off-shore oil and gas, chemical, pulp and paper industries and seawater desalination plant.

Classification

EN	1600: E 20 25 5 Cu N L R 5 3
AWS	A5.4: E 385-16

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Ni	Mo	Cu
≤ 0.03	1.3	0.4	21	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
As Welded	≥ 320	≥ 510	≥ 30	≥ 70

Materials

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

Storage

Keep dry and avoid condensation.
Re-drying not generally required.
If necessary: 300-350 °C for 2 hours, 5 times max.

Current condition and welding position

AC; DC+



PA PB

Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	CBOX		DRYF	
				PC	Code	PC	Code
2.5	300	50-75	20.9	190	●	28	●
3.2	350	80-105	41.7	115	●	22	●
4.0	350	100-135	60.2	80	●	18	●