

Technical data sheet

011121MBA

Cored welding wire

TUBE S 904L-G**CLASSIFICATION**

ASME IIC SFA 5.22 / AWS A 5.22:	(EC385)
EN ISO 17633-A:	T Z 20 25 5 Cu N L M I1 1
EN ISO 17633-B:	-
Equivalent Material number:	1.4519
ASME IX Qualification	QW432 F-N° 6 QW442 A-N° 9

DESCRIPTION

- Metal cored stainless steel wire for gas shielded arc welding
- 20% chromium - 25% nickel - 5% molybdenum – 1.5% copper - low carbon deposit
- Enhanced productivity, improved weldability, better wetting properties compared to solid wires
- Excellent weld metal quality and X-ray soundness
- High welding speeds are possible in the horizontal position

APPLICATIONS

TUBE S 904L-G is suitable for welding stainless steels of similar composition and for dissimilar welds between these steels and mild, low alloy and other stainless steels. It is an alternative choice to overmatch leaner alloys such as 317LN, 1.4439 etc.

Examples:

AISI	UNS	Material number	EN Symbol
		1.4500	GX7 NiCrMoCuNb 25-20
		1.4505	X4 NiCrMoCuNb 20-18-2
		1.4506	X5 NiCrMoCuTi 20-18
		1.4536	GX2 NiCrMoCuN 25-20
	N08904	1.4539	X1 NiCrMoCu 25-20-5
		1.4585	GX7 CrNiMoCuNb 18-18

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Cu	S	P
0.02	3.5	0.4	21	25	5	1.5	0.008	0.02

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
510	320	25	-196°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
640	410	35	- 196°C: 40

SHIELDING GAS

EN ISO 14175 :	I1	Ar
	M12	Ar + 0.5 % < CO ₂ ≤ 2.5 with or without helium
	Z	Ar + CO ₂ ≤ 0.5 % with or without helium

OPERATING CONDITIONS

Current type	Gas flow rate	Stick out	Recovery
DC+ / pulsed	10 - 20 l/min.	12 - 25 mm	98 %

WELDING POSITIONS

TUBE S 904L-G is primarily used in the flat and horizontal positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm		1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M		
Spool type	S200	BS300	BS300
Weight	5 kg	15 kg	15 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.