


<b>Technical data sheet</b>  <small>011121MBA</small>	<b>Coated SMAW Electrode</b>  <b>WA TETRA V 904L-E</b>	
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### CLASSIFICATION

ASME IIC SFA 5.4 / AWS A 5.4:	E385-16
EN ISO 3581-A:	E 20 25 5 Cu N L R 3 2
Equivalent Material number :	1.4519
ASME IX Qualification	QW432 F-N° 5

### DESCRIPTION

- Rutile basic coated electrode
- Fully austenitic deposit in CrNiMoCu stainless steel – type 385
- Specially developed for the phosphate industry
- Welding of matching steel
- Service temperatures from -110°C to +350°C
- Complements Welding Alloys cored wires TETRA S 904L-G and TETRA V 904L-G

### APPLICATIONS

WA TETRA V 904L-E 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:

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	P	S	Fe
0.025	1.40	0.8	20.5	25.0	4.50	1.50	0.021	0.015	Bal.

### MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
520	320	30	+ 20°C: 70

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
650	540	37	+ 20°C: 80

### OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Current [A]	50-70	70-100	90 -130
= +	~ 70V		

Re-drying: 2-3h at 250-300°C. Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter).

### WELDING POSITIONS

All positions

### PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 350	4.0 x 350
Weight/box [kg]	4.0	5.0	5.0

Other packaging and other sizes: please consult us