


CEWELD ER 383

| TYPE | ER 385 Stainless steel Mag welding wire for the GMAW process | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--|--|-------------------------|--------------------|-------------------------|------|----------|-----|------|------|--|----------------|-------------------------|----------------------|--------------------|-------------------------|----|----------|----|---|-----------|------|-----|------|-------|------|------|------|-----|------|------|
| ANWENDUNGEN | Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| EIGENSCHAFTEN | ER 383 is used to weld base metals of similar composition to itself or to other grades of stainless steel. ER383 contains a low maximum of carbon, silicon, and sulfur to decrease the hot cracking and fissuring, while maintaining the resistance to corrosion. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| KLASSIFIKATION | AWS | A 5.9: ER383 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | EN ISO | 14343-A: G 27 31 4 Cu L | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | W.Nr. | 1.4563 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | F-nr | 6 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | FM | 5 | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GEEIGNET FÜR | Alloy 825 N08825 , Alloy 825 h Mo N08821, Alloy 28 and Alloy 20 (X1NiCrMoCu31-27-4), Alloy 904L (X1NiCrMoCu25-20-5), 1.4563, 1.4539, NiCr 21 Mo 2.4858, NiCr 21 Mo 6Cu 2.6410, X3NiCrCuMoTi27-23 1.4503 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| ZULASSUNGEN | CE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| SCHWEISSPOSITIONEN |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | <table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.4</td> <td>1.55</td> <td>0.017</td> <td>0.01</td> <td>28.2</td> <td>32.1</td> <td>3.9</td> <td>0.05</td> <td>0.95</td> </tr> </tbody> </table> | | | | | | | | | | C | Si | Mn | P | S | Cr | Ni | Mo | N | Cu | 0.02 | 0.4 | 1.55 | 0.017 | 0.01 | 28.2 | 32.1 | 3.9 | 0.05 | 0.95 |
| C | Si | Mn | P | S | Cr | Ni | Mo | N | Cu | | | | | | | | | | | | | | | | | | | | | |
| 0.02 | 0.4 | 1.55 | 0.017 | 0.01 | 28.2 | 32.1 | 3.9 | 0.05 | 0.95 | | | | | | | | | | | | | | | | | | | | | |
| MECHANISCHE GÜTEWERTE | <table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>380</td> <td>570</td> <td>38</td> <td colspan="2">100</td> <td>HRc</td> </tr> </tbody> </table> | | | | | | | | | | Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | RT | | As Welded | 380 | 570 | 38 | 100 | | HRc | | | | |
| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness | | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | RT | | | | | | | | | | | | | | | | | | | | | | | | | | |
| As Welded | 380 | 570 | 38 | 100 | | HRc | | | | | | | | | | | | | | | | | | | | | | | | |
| RÜCKTROCKNUNG | Not required | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| GAS ACC. EN ISO 14175 | I1, M21, I3 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |