



CEWELD AA 904LP

TYPE Rutile fluxcored austenitic filler metal with excellent corrosion resistance

APPLICATIONS Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants

PROPERTIES The Ceweld AA 904LP is used for welding materials of similar chemical composition which are used for fabrication of equipment and vessels for handling of sulfuric acid and many chloride containing media. This fluxcored wire may also find applications for joining Type 317L material where improved corrosion resistance in specific media is needed. In order to reduce the propensity for fissuring and hot cracking, the low melting constituents such as carbon, silicon, and phosphorus are controlled to lower levels in this alloy. Suitable in all positions.

CLASSIFICATION

| | |
|--------|-----------------------------------|
| AWS | A 5.22: ~385T1-4 |
| EN ISO | 17633-A: T 20 25 5 Cu N L P M21 2 |
| W.Nr. | 1.4539 |
| F-nr | 6 |
| FM | 5 |

SUITABLE FOR 1.4465, 1.4500, 1.4505, 1.4506, 1.4519, 1.4531, 1.4536, 1.4537, 1.4538, 1.4539, 1.4573, 1.4585, 1.4586, 1.4539, 1.4537, 1.4519, 1.4505
 X1CrNiMoN25-25-2, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X2NiCrMoCuN25-20-5, X2NiCrMoCuN20-18, X4NiCrMoCuNb 20-18-2, X5NiCrMoCuTi20-18, X5NiCrMoCuNb22-18
 ASTM A182,
 UNS N08904, S31726
 Uranus B6, 904L, Z2NCDU25-20,

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | P | Cr | Ni | Mo | N | Cu |
|------|------|------|-------|----|------|----|------|------|
| 0.03 | 0.65 | 1.55 | 0.025 | 21 | 25.5 | 5 | 0.15 | 1.35 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | -196°C | | |
| As Welded | 425 | 665 | 35 | 60 | | HRC |

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M21



CEWELD AA 904LP

AA 904LP 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663413734 |