





TYPE Rutile fluxcored austenitic filler metal with excelent corrosion resistance

APPLICATIONS Tanks and process vessels, piping systems, agitators, rotors, cast pumps and valves for use in

fertilizer, phosphoric-, sulphuric-, acetic- and acid environments.

PROPERTIES The Ceweld AA 904L 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 only in down-hand positions.

CLASSIFICATION **AWS** A 5.22: ~385T0-4

> EN ISO 17633-A: T Z 20 25 5 Cu N L R M21 3

W.Nr. 1.4539 F-nr 5 FΜ 6

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

С	Si	Mn	Р	S	Cr	Ni	Мо	N	Cu
0.035	0.5	3.5	0.02	0.002	20	25.5	4.5	0.072	1.6

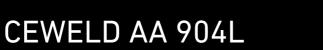
MECHANICAL PROPERTIES

Heat	R _{P0,2} (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
Treatment				-196°C	
As Welded 430 640 3		32	35	HRc	

REDRYING Not required

GAS ACC. EN ISO 14175 M21







AA 904L 1.2MM

Packaging	KG/unit	EanCode		
BS-300	15	8720682050279		