




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																		
PROPRIÉTÉS	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 for all positions.																		
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.22: ~385T1-4</td> </tr> <tr> <td>EN ISO</td> <td>17633-A: T 20 25 5 Cu N L P M21 2</td> </tr> <tr> <td>W.Nr.</td> <td>1.4539</td> </tr> <tr> <td>F-nr</td> <td>6</td> </tr> <tr> <td>FM</td> <td>5</td> </tr> </table>	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								
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CONVIENT POUR	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,																		
AGRÉMENTS	CE																		
POSITIONS DE SOUDAGE																			
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.65</td> <td>1.55</td> <td>0.025</td> <td>21</td> <td>25.5</td> <td>5</td> <td>0.15</td> <td>1.35</td> </tr> </tbody> </table>	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
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		-196°C																	
As Welded	425	665	35	60		HRC													
ETUVAGE	140°C / 24 hr																		
GAS ACC. EN ISO 14175	M21																		



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AA 904LP 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663413734