

Classifications							
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	Mat. No.				
W 20 25 5 Cu L	SS385	ER385	1.4519				
Characteristics and typical fields of application							
Stainless; resistant to intercrystalline corrosion and wet corrosion up to 350 °C (662 °F). Good corrosion resistance similar to matching steels / cast steel grades, above all in reducing environment. For joining and surfacing work on matching austenitic CrNiMoCu steels / cast steel grades. For joining these steels with unalloyed / low-alloy steels/cast steel grades.							
Base materials							
TÜV-certified parent metal 1.4505 – X4NiCrMoCuNb20-18-2, 1.4539 – X1NiCrMoCu25-20-5 1.4439 – X2CrNiMoN17-13-5, 1.4465 – X1CrNiMoN25-25-2, 1.4537 – X1CrNiMoCuN25-25-5 and others, as well as ferritic steels up to S355J; matching Cr-Ni steels with high Mo content; UNS N08904, S31726							
Typical analysis of the TIG rods (wt.-%)							
	C	Si	Mn	Cr	Mo	Ni	Cu
wt-%	< 0.025	0.20	2.5	20.5	4.8	25.0	1.5
<b>Structure:</b> Austenite							
Mechanical properties of all-weld metal							
Heat-treatment	Yield strength R <sub>p0.2</sub>	Yield strength R <sub>p1.0</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J		
	MPa	MPa	MPa	%	+20 °C		
aw	350	380	550	35	120		
Operating data							
<b>Polarity:</b> DC (–)	<b>Shielding gas:</b> (EN ISO 14175) I1	<b>Marks:</b> ✦ W 20 25 5 Cu L / ER385		<b>ø (mm)</b>	<b>L mm</b>		
				1.6	1000		
				2.0	1000		
				2.4	1000		
				3.2	1000		
Welding instruction							
Materials		Preheating		Postweld heat treatment			
Matching / similar steels / cast steel grades		None		None. If necessary solution annealing at 1120 °C (2048 °F)			
Combinations with unalloyed / low-alloy steels / cast steel grades		According to unalloyed / low alloy parent metal mostly not necessary		None			
Approvals							
TÜV (04301), CE							