



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



**TYPISCHE CHEMISCHE
ANALYSE DES
FÜLLMETALLS (%)**

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

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	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