



# CEWELD AA 904L

|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                     |                      |                    |                         |    |      |          |       |     |
|----------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|----------------------|--------------------|-------------------------|----|------|----------|-------|-----|
| TYPE                                               | Rutile fluxcored austenitic filler metal with excelent corrosion resistance                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                     |                      |                    |                         |    |      |          |       |     |
| ANWENDUNGEN                                        | Tanks and process vessels, piping systems, agitators, rotors, cast pumps and valves for use in fertilizer, phosphoric-, sulphuric-, acetic- and acid environments.                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                      |                    |                         |    |      |          |       |     |
| EIGENSCHAFTEN                                      | 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. |                                     |                      |                    |                         |    |      |          |       |     |
| KLASSIFIKATION                                     | 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                                   |                      |                    |                         |    |      |          |       |     |
|                                                    | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 6                                   |                      |                    |                         |    |      |          |       |     |
| GEEIGNET FÜR                                       | <b>1.4539 / 904L CrNiMoCu / 20 25 5 Cu L</b><br>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<br>X1CrNiMoN25-25-2, X1NiCrMoCu 25-20-5, X1CrNiMoCuN 25-25-5, X2NiCrMoCuN25-20-5, X2NiCrMoCuN20-18, X4NiCrMoCuNb 20-18-2, X5NiCrMoCuTi20-18, X5NiCrMoCuNb22-18<br>ASTM A182,<br>UNS N08904, S31726<br>Uranus B6, AISI 904L, Z2NCDU25-20,                                                                                                                                                                                      |                                     |                      |                    |                         |    |      |          |       |     |
| ZULASSUNGEN                                        | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                     |                      |                    |                         |    |      |          |       |     |
| SCHWEISSPOSITIONEN                                 | <div>PA</div> <div>PB</div>                                                                                                                                                                                                                                                                                                                                                                                    |                                     |                      |                    |                         |    |      |          |       |     |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Si                                  | Mn                   | P                  | S                       | Cr | Ni   | Mo       | N     | Cu  |
|                                                    | 0.035                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 0.5                                 | 3.5                  | 0.02               | 0.002                   | 20 | 25.5 | 4.5      | 0.072 | 1.6 |
| MECHANISCHE GÜTEWERTE                              | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | R <sub>p0,2</sub> (MPa)             | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |    |      | Hardness |       |     |
|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                     |                      |                    | -196°C                  |    |      |          |       |     |
|                                                    | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 430                                 | 640                  | 32                 | 35                      |    |      | HRc      |       |     |
| RÜCKTROCKNUNG                                      | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                     |                      |                    |                         |    |      |          |       |     |
| GAS ACC. EN ISO 14175                              | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                     |                      |                    |                         |    |      |          |       |     |



# CEWELD AA 904L

AA 904L 1.2MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720682050279 |