

<b>Classifications</b>							
EN ISO 14343-A	EN ISO 14343-B	AWS A5.9	Mat. No.				
G 20 25 5 Cu L	SS385	ER385	1.4519				
<b>Characteristics and typical fields of application</b>							
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.							
<b>Base materials</b>							
TÜV-certified parent metal 1.4505 – X4NiCrMoCuNb20-18-2 1.4539 – X1NiCrMoCu25-20-5 mit 1.4439 – X2CrNiMoN17-13-5 1.4465 – X1CrNiMoCuN25-25-2 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							
<b>Typical analysis of solid wire (wt.-%)</b>							
	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							
<b>Mechanical properties of all-weld metal</b>							
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	370	550	35	55		
<b>Operating data</b>							
<b>Polarity:</b> DC ( + )	<b>Shielding gas:</b> (EN ISO 14175) M12, M13		<b>ø (mm)</b> 1.0 1.2	<b>Spool:</b> B300 B300			
<b>Welding instruction</b>							
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					
<b>Approvals</b>							
TÜV (04302), CE							