

20.25.4.Cu

TIG (GTAW)

SOLID WIRE FOR TIG FOR ALLOY 904L

PRODUCT DESCRIPTION

Solid wire for TIG welding.

CLASSIFICATIONS

AWS A5.9M	ER385
ISO 14343-A	W 20 25 5 Cu L
ISO 14343-B	SS385

ASME IX QUALIFICATION

QW432	F-No 6
QW442	A-No 9

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min.	--	1.0	0.25	--	--	19.5	24.0	4.2	1.2
Max.	0.025	2.5	0.50	0.015	0.020	21.5	26.0	5.2	2.0
Typical	0.01	1.7	0.3	0.001	0.015	20	25	4.5	1.5

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded

Tensile strength (MPa)	650
0.2% proof strength (MPa)	490
Elongation [%] 4d	35
5d	32
Impact ISO-V(J) +20°C	210
Hardness cap/mid HV	175/195

TYPICAL OPERATING PARAMETERS

Shielding	Current	Diameter (mm)	Voltage
Argon*	DC-	2.4	100A, 12V

* Also required as a purge for root runs.

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.6	5	PE TUBE	T20254CU-16
2.0	5	PE TUBE	T20254CU-20
2.4	5	PE TUBE	T20254CU-24

STAINLESS STEELS