



**MANUFACTURERS OF A DIVERSE RANGE OF
ADVANCED WELDING CONSUMABLES**

**SECTION
13**

WI-0304 DS174 NS-385R, Rev. 0, Date 01.09.2008

NS-385R	FILLER ROD FOR WELDING FULLY AUSTENITIC STAINLESS STEEL CONTAINING A NOMINAL 20Cr-25Ni-5Mo-2Cu WHEN GOOD CORROSION RESISTANCE IS SPECIFIED					DATA SHEET NO. 174					
						SPECIFICATION		AWS A5.9			BS EN 12072
CLASSIFICATION	ER385			W 20 25 5 Cu L							
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Cr	Ni	Mo	Mn	Si	P	S	Cu	Fe
	MIN	-	19.5	24	4.2	1.0	-	-	-	1.2	
	MAX	0.025	21.5	26	5.2	2.5	0.5	0.02	0.02	2.0	
	TYPICAL	0.01	20	25	4.5	1.6	0.35	0.015	0.001	1.4	Bal.
WELD METAL PROPERTIES (AS WELDED)	<u>PROPERTY</u>	<u>UNITS</u>	<u>MIN.</u>	<u>TYPICAL</u>	<u>OTHERS</u>						
	Tensile strength	N/mm ²	520	775							
	0.2% Proof stress	N/mm ²		520							
	Elongation on 4d	%	30	42							
Impact energy -20°C	J		200								
OTHER DATA	Argon mainly use as shielding gas										
RELATED PRODUCTS	Please contact our Technical Department for detail.										