

SELECTARC Inox 385

Stainless Steel Electrode **Highly Corrosion Resistant**

Classification

AWS A5.4 : E385 - 16 EN 1600 : E 20 25 5 Cu N L R 12

ISO 3581-A : E 20 25 5 Cu N L R 12

Approvals : CE

Characteristics

Rutile - basic coated electrode for welding fully austenitic highly corrosion resistant stainless steels as 904L, B6. Good weldability in all positions, except vertical down, stable arc, good slag removal. Uniform finely rippled weld beads. Due to its alloy composition high Mo - content and Cu, the weld metal is suited against attacks by phosphoric and sulphuric acids. It shows a high resistance against pitting and stress corrosion in chloride containing media. It is used at service temperature upto 400°C.

Applications

Pulp and Paper industry, Transport containers, Installations of Chemical Industry.

Base Materials

UNS	ALLOY	EN 10088 Material No		CLI
S31703	317L	X2CrNiMo18-15-4	1.4438	
	317 LNM	X2CrNiMoN 17-13-5	1.4439	
		G-X7NiCrMoCuNb 25-20	1.4500	
		X5CrNiMoCuTi 20-18	1.4506	
N08904	904L	X1NiCrMoCu 25-20-5	1.4539	URB6(N)

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Fe				
0.028	0.80	1.40	20.50	25.00	4.50	1.50	base				

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impac	t (KV)
	Rm (MPa)	Rp0.2 (MPa)	A ₅	Temp.ºC	J
AW	580	375	32	+ 20	70

Welding Current & Instructions

Electrode	ØxL (mm)	2.5 x 300	3.2 x 350	4.0 x 350
Current	(A)	50 - 75	70 - 100	90 - 130

Redrying of electrode for 2-3 hrs at 250 - 300°C before use. Guide electrodes with a slight inclined angle towards the direction of travel with a short arc. Prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter). Maintain Interpass temperature : < 150°C













2F/PB

3G/PF

4G/PE

2G/PC Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. Fumes: Consult information on MSDS, available upon request.

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