

# ROYAL –ER 385 Stainless Steel Solid Filler Wire Rods

AWS/ SFA A 5.9 ER 385

## Description

This solid filler wire rods deposit 20.5 % Cr, 25 % Ni, 4.7 % Mo and 1.5 % Cu weld metal with good finish and free from any defects.

## Typical Applications

It is used for welding of ASTM B625, B673, B674 and B677 material for handling of sulphuric acid and many chlorides containing. Media; for welding of type 904L material.

## Packing

Each Packets content 5 kg of Wire Rods having length 1000mm  
Also available in MIG wire Size 0.80 , 1.00, 1.20, 1.60 mm in 12.5 kg Spool.

MIG TIG WIRES

## Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%	Cr %	Ni %	Mo%	Cu%
0.025Max	1.00 – 2.50	0.50 Max	0.03 Max	0.02 Max	19.5 - 21.5	24.0– 26.0	4.20 - 5.20	1.20-2.0

## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	ELONGATION ( L = 4d ) %	Shielding Gas
520	30 % Min	Ar + 2% Oxygen