

## MIG-MAG Wires Stainless and Heat resistant steels

Inertfil 904L is a solid wire for welding stainless steels type 904L. Low carbon content. Very good resistance to intergranular and pitting corrosion.

Classification	
AWS	A5.9: ER 385 L
EN	12072: G 20 25 5 Cu L

Approvals	Grades
TÜV	

see Appendix, Classification Society Approvals, for details pag. 521

### Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Cu	N	Ferrite
0.025	1.90	0.40	≤ 0.020	≤ 0.020	20	25	4.50	-	1.50	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -70°C	Hardness
As Welded	≥ 410	≥ 560	≥ 35	≥ 100	-

Gas test: Acc. To EN 439: M13(Cargal1)

**Shielding Gas:** Acc. To EN 439: M13(Cargal1)

### Materials


URANUS B6; AISI 904L; 1.4539 (X1NiCrMoCu25-20-5); 1.4439 (X2CrNiMoN17-13-5); 1.4537 (X1CrNiMoCuN25-25-5)

### Storage

Keep dry and avoid condensation

### Current condition and welding position

**DC+**



PA PB PC PF PE PF2

**Packaging data:** BS300 Kg. 15

Diameters	1,0	1,2			
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