

TIG Rods

Stainless and Heat resistant steels

Inertrod 904L is a TIG rod for the welding of stainless steels type AISI 904L with low carbon content. Very good resistance to intergranular and pitting corrosion.

Classification	Approvals	Grades
AWS A5.9; ER 385 L		
EN 12072: W 20 25 5 Cu L		

### 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	≥ 320	≥ 520	≥ 30	≥ 100	-

Gas test: Acc. To EN 439: I1(Arcal1)

**Shielding Gas:** Acc. To EN 439: I1(Arcal1)

### Materials

1.4519

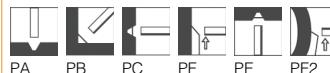
URANUS B6; AISI 904L; 1.4539 (X1NiCrMoCu25-20-5); 1.4439 (X2CrNiMoN17-13-5); 1.4537 (X1CrNiMoCuN25-25-5)

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC-



**Packaging data:** Tube 5 kg

Diameters (L: 1000 mm)	1,6	2,0	2,4			
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Further forms of delivery on request.