

INERTROD 904L

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

Approvals	Grades

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 ²	Tensile Strength N/mm ²	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		

Further forms of delivery on request.