

## OK Tigrod 385

Bare corrosion resisting welding rods for welding of austenitic stainless steels of type 20Cr-25Ni-4.5Mo-1.5Cu. The weld metal has a good resistance to stress corrosion and intergranular corrosion and shows a very good resistance to attack in nonoxidizing acids. The resistance to pitting and crevice corrosion is better than for ordinary 18Cr-8Ni-Mo-steels.

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| <b>Классификации</b> | AWS A5.9 : ER385<br>EN ISO 14343-A : W 20 25 5 CuL |
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| <b>Тип сплава</b>   | Fully austenitic (20 % Cr - 25 % Ni - 5 % Mo - 1.5 % Cu - Low C) |
| <b>Защитный газ</b> | I1, I2, I3 (EN ISO 14175)  |

### Типичные свойства образца с V-образным надрезом по Шарпи

| Состояние    | Температура испытания | Работа удара |
|--------------|-----------------------|--------------|
| После сварки | 20 °C                 | 150 J        |

### Хим. состав проволоки

| C    | Mn  | Si  | Ni   | Cr   | Mo  | Cu  | N    |
|------|-----|-----|------|------|-----|-----|------|
| 0.01 | 1.7 | 0.4 | 25.0 | 20.0 | 4.4 | 1.5 | 0.05 |