

Exaton 385

385 welding wire is suitable for joining steels of the 20Cr/25Ni/4.5Mo/1.5Cu type - for example Sandvik 2RK65 used in many areas of the process industry, such as in the production of acetic acid, sulfuric acid, terephthalic or tartaric acid and vinyl chloride. It is also suitable for use in cooling operations involving sea water or heavily polluted river water. It is used for TIG-welding.

Classifications Wire Electrode	SFA/AWS A5.9 : ER385 EN ISO 14343-A : W 20 25 5 Cu L Werkstoffnummer : ~1.4519
Approvals	CE EN 13479 VdTUV 02223

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Austenitic, 20% Cr, 25% Ni, 4.5% Mo, 1.5% Cu, low C
Shielding Gas	I1, I3, R1 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	200 J (148 ft-lb)
As Welded	-196 °C (-321 °F)	160 J (118 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.02	1.8	0.3	0.001	0.014	24.8	19.8	4.3	0.01	1.4

Typical Weld Metal Analysis %

N	Nb	Co
0.06	0.01	0.1

Typical Wire Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	Al	Cu
0.01	1.8	0.3	0.002	0.013	25	20	4.3	0.02	1.5

Typical Wire Composition %

N	Nb	Ti	Co
0.05	0.01	0.003	0.1