



CEWELD ER 383

TYPE	ER 385 Stainless steel Mag welding wire for the GMAW process																													
ANWENDUNGEN	Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants																													
EIGENSCHAFTEN	ER 383 is used to weld base metals of similar composition to itself or to other grades of stainless steel. ER383 contains a low maximum of carbon, silicon, and sulfur to decrease the hot cracking and fissuring, while maintaining the resistance to corrosion.																													
KLASSIFIKATION	AWS	A 5.9: ER383																												
	EN ISO	14343-A: G 27 31 4 Cu L																												
	W.Nr.	1.4563																												
	F-nr	6																												
	FM	5																												
GEEIGNET FÜR	Alloy 825 N08825 , Alloy 825 h Mo N08821, Alloy 28 and Alloy 20 (X1NiCrMoCu31-27-4), Alloy 904L (X1NiCrMoCu25-20-5), 1.4563, 1.4539, NiCr 21 Mo 2.4858, NiCr 21 Mo 6Cu 2.6410, X3NiCrCuMoTi27-23 1.4503																													
ZULASSUNGEN	CE																													
SCHWEISSPOSITIONEN																														
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>N</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.4</td> <td>1.55</td> <td>0.017</td> <td>0.01</td> <td>28.2</td> <td>32.1</td> <td>3.9</td> <td>0.05</td> <td>0.95</td> </tr> </tbody> </table>										C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu	0.02	0.4	1.55	0.017	0.01	28.2	32.1	3.9	0.05	0.95
C	Si	Mn	P	S	Cr	Ni	Mo	N	Cu																					
0.02	0.4	1.55	0.017	0.01	28.2	32.1	3.9	0.05	0.95																					
MECHANISCHE GÜTEWERTE	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>380</td> <td>570</td> <td>38</td> <td colspan="2">100</td> <td>HRc</td> </tr> </tbody> </table>										Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT		As Welded	380	570	38	100		HRc				
Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness																								
				RT																										
As Welded	380	570	38	100		HRc																								
RÜCKTROCKNUNG	Not required																													
GAS ACC. EN ISO 14175	I1, M21, I3																													