

# OK Tigrod 385

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

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| <b>Classifications Wire Electrode:</b> | SFA/AWS A5.9:ER385, EN ISO 14343-A:W 20 25 5 Cu L |
| <b>Approvals:</b>                      | VdTUV 05444 (IT)                                  |

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

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| <b>Alloy Type:</b> | Fully austenitic (20 % Cr - 25 % Ni - 5 % Mo - 1.5 % Cu - Low C) |
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## Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|-----------|----------------|------------------|------------|
| As welded | 340 MPa        | 540 MPa          | 37 %       |

## Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------|---------------------|--------------|
| As welded | 20 °C               | 120 J        |

## Typical Wire Composition %

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