

OK Autrod 385

A continuous, solid, corrosion-resistant, chromium-nickel-molybdenum-copper wire for welding austenitic stainless alloys of the 20% Cr, 25% Ni, 5% Mo, 1.5% Cu, low C types. OK Autrod 385 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 crevice corrosion is better than that of ordinary 18% Cr, 8% Ni, Mo steels. The alloy is widely used in many applications related to the process industry.

Classifications Wire Electrode:	EN ISO 14343-A:G 20 25 5 Cu L, SFA/AWS A5.9:ER385
Approvals:	VdTÜV 04905 (IT)

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

Alloy Type:	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

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
0.8 mm	55-160 A	15-24 V	4.0-17.0 m/min	1.0-4.1 kg/h
1.0 mm	80-240 A	15-28 V	3.5-18.0 m/min	1.5-6.0 kg/h
1.2 mm	100-300 A	15-29 V	3.0-14.0 m/min	1.6-7.5 kg/h
1.6 mm	230-375 A	23-31 V	5.5-9.0 m/min	5.2-8.6 kg/h