MIG 20/25CU

Old reference: MIG 385

Classification

ISO 14343-A : G 20 25 5 Cu L
AWS A5.9 : ER385

Material N° : 1.4519

Description & Applications

Very low carbon content solid wire for joining of fully austenitic stainless steels (Uranus B6*, 904L…). Very good resistance to attacks by phosphoric and sulphuric acids. High resistance against pitting and stress corrosion in chloride containing media.

* Trademark of CREUSOT LOIRE

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.015	0.4	1.8	20.0	25.0	4.5	1.5	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
330	550	37	+20°C 120 -196°C 80

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8 1.0 1.2 1.6	100-150 120-200 140-220 180-260	22-27 24-28 24-28 24-30	Ar+20%He+0.05% CO_2 Ar + 2%CO_2 Ar + 1%O_2 18-20 l/min

Ind.10

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.