

Description and Application

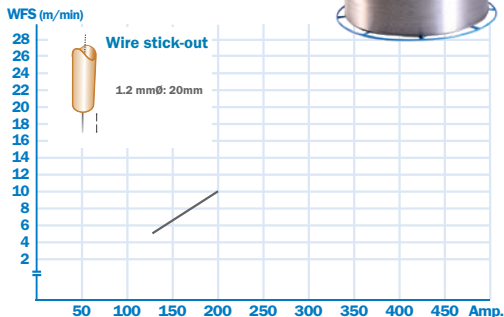
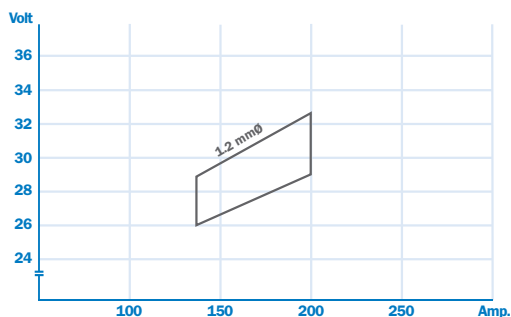
DW-904L is a rutile flux cored wire suited for the welding of 904L stainless steel (20Cr-25Ni-5Mo-Cu) which is used for manufacturing chemical vessels for use with Phosphoric acid and Sulfuric acid. This wire can be used in all positions with quite stable arc and low spatter.

DW-904L weld metal has a full austenitic micro structure which is sensitive to hot cracking.

High amperage and high welding speed should be avoided to minimize the risk of hot cracking especially for the root pass in butt joint welding.



Recommended Parameter Range, for flat position



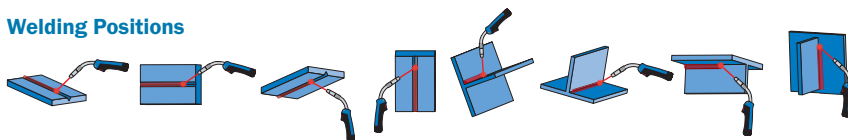
Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.66	1.56	0.024	0.003	25.3	20.9	4.8	0.13	-	-	-	-

Typical Mechanical Properties

	R _s (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-196°C
	423	664	36	61
Guaranty	min.320	min.510	min.25	-

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-