FW 385

CODIFICATION:

AWS : SFA 5.9 ER385
EN ISO: 14343-A W 20 25 5 Cu L

CHARACTERISTICS AND APPLICATIONS:

FW 385 is a solid wire for TIG welding, available in bright finish, gives smooth flow, stable arc and spatter free under optimum welding conditions. It gives radiographic quality weld deposit. Wire contains low carbon 20Cr - 25Ni - 5Mo - 2Cu which exhibits excellent resistance to corrosion in non oxidizing media like sulfuric acid, phosphoric acid, acetic acid, formic acid, fatty acids, oxalic acid etc. It is ideally suited for welding materials for application where phosphoric, sulfuric acids, and other non-oxidizing solutions are encountered. The addition of Mo and Cu helps in resisting corrosive attack of these solutions. It is particularly suited for welding Carpenter 20, HV9, HV9A, Uranus B6, UHB 904L, Sandvik 2RK65, and similar materials which are used for these service conditions.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
%	0.022	1.2	0.30	0.015	0.018	20.0	25.0	4.80	1.60

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 5d) %
540	32.0

SHIELDING GAS: Argon

CURRENT CONDITIONS: DCEN

WELDING POSITIONS: H, F, VU, OH

PACKING:

STANDARD SIZE:	Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 1000 mm each.
QUANTITY	5 kgs wire put in an air-tight polythene bag and finally packed in a plastic container. Identification – AWS code is punched on each wire.