

TECHNICAL DATASHEET - WELDING CONSUMABLE

AWS Code:	ER385
Product Code:	RW 385
Werkstoff No.:	-
MIG Certification:	CE - UKCA
TIG Certification:	CE - UKCA

EQUIVALENT OF OTHER STANDARD

EN ISO 14343-A:2017 Nominal Composition	AWS A5.9:2017 Alloy Designation	EN ISO 14343-B:2017 Alloy Type	AWS A5.9:2017 Composition Designation
20 25 5 Cu L	ER385	SS385	ER385

DESCRIPTION AND APPLICATIONS

RW 385 is a stainless welding wire for applications requiring high corrosion resistance in sulfuric acid and chloride-containing environments. It can also be used for joining similar-composition or dissimilar metals. Used in sulfuric acid and chloride-containing environments. Preferred for joining similar-composition or dissimilar metals. Its copper-containing high-alloy structure is suitable for acidic and chloride-containing environments.

TYPICAL CHEMICAL COMPOSITION (%)

	Min.	Max.
C	-	0,025
Mn	1,00	2,50
Si	-	0,50
S	-	0,020
P	-	0,020
Cr	19,5	21,5
Ni	24,0	26,0
Mo	4,20	5,20
Cu	1,20	2,00
N	-	-
Nb	-	-
Ti	-	-

DIAMETER

MIG sizes	0,8 0,9 1,0 1,14 1,2 1,6
TIG sizes	0,8 0,9 1,0 1,2 1,6 2,0 2,4 3,2 4,0
SAW sizes	1,6 2,0 2,4 3,2 4,0

PACKAGING

MIG	Blue Metallic Wire Basket BS300: 15 Kg. Plastic Spool D300: 15 Kg. Plastic Spool D200: 5 Kg. Wooden/Metallic Bulk Spool: 250 Kg. Drum: 250-400 Kg.
TIG	Carton Boxes/Tubes: 5 Kg. (1000 mm Rod Length)
SAW	Metallic Wire Basket K415 Wooden/Metallic Bulk Spool: 250 Kg. Drum: 300 Kg.

Note: Safety Data Sheet is available on request.