



Stainless Steel BARE WIRE DATA SHEET

exocor 385

DESCRIPTION

Exocor 385 (904L) is used primarily for welding of ASTM B625, B673, B674 and B677 (UNS N08904) for the handling of sulphuric acid and many chloride containing media. This filler metal may also be used to join Type 317L material, where improved corrosion resistance in specific media is needed. Exocor 385 may be used for joining UNS N08904 base metals to other grades of stainless steel.

The elements C, S, P and Si are specified at lower maximum levels to minimize weld metal hot cracking and fissuring (while maintaining corrosion resistance) frequently encountered in fully austenitic weld metals.

TYPICAL CHEMICAL VALUES

C	Cr	Ni	Mo	Mn	Si	P	S	Cu
0.02	20.5	25.0	4.7	1.9	0.4	0.01	0.02	1.5

WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.093	29 - 32	300 - 350	20 - 30 IPM	Record IN Flux
	.125	29 - 32	400 - 550	20 - 30 IPM	Record IN Flux
	.156	29 - 32	500 - 650	20 - 30 IPM	Record IN Flux
GMAW	.035	29 - 33	160 - 180	30 - 50 CFH	98/99% Ar + 2/1% O ₂
	.045	29 - 33	180 - 220	30 - 50 CFH	or
	.062	29 - 33	210 - 250	30 - 50 CFH	97% Ar + 3% CO ₂
GTAW	.093	Direct Current; Electrode –		30 - 40 CFH	100% Ar

MECHANICAL PROPERTIES

Tensile Strength:	86,500 PSI	600 MPA
Yield Strength:	59,500 PSI	410 MPA
Elongation:	36%	

CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.9, Class ER385**. ISO 14343A, Class 20 25 5 Cu L and ISO 14343B, Class SS385.