DATASHEET RW 385 – TIG rods

Description and Applications
Austenitic stainless steel welding wire, normally used for welding application requiring a good corrosion resistance in sulphuric acid and chloride containing media. It is also used to join parent metals like AISI 317L or for dissimilar welding.

Rodacciai denomination and approximate equivalent with other standards

	RW 385
EN ISO 14343-A:2009	W 20 25 5 Cu L
EN ISO 14343-B:2009	SS 385
AWS A5.9-2012	ER 385

Filler metal properties
Chemical composition (nominal) in %

	C	**Mn**	**Si**	**S**	**P**	**Cr**	**Ni**	**Mo**	**Cu**	**Co**	**Al**	**N**	**Nb**	**B**
min		1,50	0,25			19,60	24,70	4,20	1,25			0,040		
max	0,015	2,00	0,45	0,002	0,015	20,40	25,30	4,80	1,75	0,50	0,050	0,060	0,050	0,003

Metal properties
The following data are typical for non-heat treated weld metal from TIG welding with I1 DIN EN ISO 14175 as shielded gas.

Expected minimum mechanical properties of all weld metal

Temperature	°C	20
Yield strength, Rp 0,2	N/mm²	410
Tensile strength, Rm	N/mm²	600
Elongation, A5	%	35
Impact energy, ISO – V	J	120

Sizes and marking
Standard sizes : diam. 1,00 – 1,20 – 1,60 – 2,00 – 2,40 – 3,20 and 4,00 mm
Tolerances on diameter : + 0,01 / - 0,04 mm
Marking : Each rod is stamped one end with ER 385

Packaging forms
White carton boxes of 5 kg.
Red, white or blue coloured cardboard tubes of 5 kg.
Wooden crates of 250 kg.