DATASHEET RW 385 – MIG wire

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	G 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 MIG welding with M1 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	320
Tensile strength, Rm	N/mm²	540
Elongation, A5	%	37
Impact energy, ISO – V	J	120

Packaging forms
Blue metallic wire baskets BS300 of 15 kg.
Plastic spools D300 of 12,5 kg for diam. 0,80 mm and of 15 kg for the other diameters.
Plastic spools D200 of 5 kg.
Drum packaging of about 150 kg for diameter 0,80 mm and of about 250 kg for the other diameters.
Diameters : 0,80 – 0,90 – 1,00 – 1,20 – 1,60 mm.