

DATASHEET RW 385 – SAW 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	S 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

Expected minimum mechanical properties of all weld metal in combination with flux

Temperature	°C	20
Yield strength, Rp 0,2	N/mm ²	320
Tensile strength, Rm	N/mm ²	510
Elongation, A5	%	30
Impact energy, ISO – V	J	100

Packaging forms

Wire basket K415 of 25 kg.

Drum packaging of about 300 kg for diameter 2,00 – 4,00 mm.

Diameters : 1,60 – 2,00 – 2,40 – 3,20 – 4,00 mm