



# CEWELD ER 383

**TYPE** ER 385 Stainless steel Mag welding wire for the GMAW process

**ANWENDUNGEN** Tanks and process vessels, Piping systems, agitators, rotors, cast pumps and valves for use in the fertilizer, phosphoric, sulphuric and acetic acid plants

**EIGENSCHAFTEN** ER 383 is used to weld base metals of similar composition to itself or to other grades of stainless steel. ER383 contains a low maximum of carbon, silicon, and sulfur to decrease the hot cracking and fissuring, while maintaining the resistance to corrosion.

**KLASSIFIKATION**

|        |                         |
|--------|-------------------------|
| AWS    | A 5.9: ER383            |
| EN ISO | 14343-A: G 27 31 4 Cu L |
| W.Nr.  | 1.4563                  |
| F-nr   | 6                       |
| FM     | 5                       |

**GEEIGNET FÜR** Alloy 825 N08825 , Alloy 825 h Mo N08821, Alloy 28 and Alloy 20 ( X1NiCrMoCu31-27-4 ), Alloy 904L ( X1NiCrMoCu25-20-5 ), 1.4563, 1.4539, NiCr 21 Mo 2.4858, NiCr 21 Mo 6Cu 2.6410, X3NiCrCuMoTi27-23 1.4503

**ZULASSUNGEN** CE

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE  
ANALYSE DES  
FÜLLMETALLS (%)**

| C    | Si  | Mn   | P     | S    | Cr   | Ni   | Mo  | N    | Cu   |
|------|-----|------|-------|------|------|------|-----|------|------|
| 0.02 | 0.4 | 1.55 | 0.017 | 0.01 | 28.2 | 32.1 | 3.9 | 0.05 | 0.95 |

**MECHANISCHE GÜTEWERTE**

| Heat Treatment | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Impact Energy (J) ISO-V | Hardness |
|----------------|----------------------------|-------------------------|-----------|-------------------------|----------|
|                |                            |                         |           | RT                      |          |
| As Welded      | 380                        | 570                     | 38        | 100                     | HRc      |

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175** I1, M21, I3