



FCW 904L

904L type Rutile flux cored wire
High productivity

Classification

AWS A5.22 : ~E385T0-4

ISO 17633-A : T Z 20 25 5 Cu L R M21 3

Description & Applications

Rutile flux cored wire for gas shielded (Ar + CO₂) arc welding for 904L stainless steel type such as Ur B6™. Very good resistance to corrosion by sulphuric, hydrochloridric or phosphoric acids. Used in flat position only with high productivity.

Main applications: Paper industry, storage and transportation tanks...

Base Materials

UNS	EN 10088	N° Mat.
	G-X7 NiCrMoCuNb 25-20	1.4500
	X4 NiCrMoCuNb 20-18-2	1.4505
	X5 NiCrMoCuTi 20-18	1.4506
	G-X2 NiCrMoCuN25-20	1.4536
N08904	X1NiCrMoCu 25-20-5	1.4539
	G-X7CrNiMoCuNb 18-18	1.4585

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	Co	P	S
Min											
Max	Not specified										
Type	0.03	0.50	3.0	21.0	25.5	4.9	1.6	0.01	0.03	0.015	0.008

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min				
Max				
Type	430	640	32	-196°C 34

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.2	100 - 250	23 - 32	12 - 25	ISO 14175: M20/M21 (Ar+CO ₂) 10-20 L/min

FT En-CN26-180914

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr

