



# MIG 27/31CU

Old reference: MIG 383

## Classification

AWS A5.9 : ER383

ISO 14343-A : G 27 31 4 Cu L

## Description & Applications

Very low carbon content GMAW solid wire for joining of fully austenitic stainless steels (Uranus B28, Sanicro 28...). Very good resistance to attacks by phosphoric and sulphuric acids. High resistance against pitting and stress corrosion in chloride containing media.

NB Sanicro is a trade name of Sandvik, Uranus is a trade name of Creusot Loire Industries

## Base materials

UNS	Alloy	EN 10088	Material N°	UGINE / CLI
N08028	28	X1NiCrMoCu31-27-4	1.4563	URANUS B28
N08904	904L	X1NiCrMoCu25-20-5	1.4539	URANUS B6

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.015	0.15	1.8	27.0	31.0	3.5	1.0	<0.02	<0.01	Rem.

## All Weld Metal Mechanical Properties

R <sub>p0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> ( % )	KV ( J )	
330	550	35	+20°C	100
			-196°C	50

## Welding Current & Instructions

Welding mode	Ø wire (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	100-150	22-27	Ar+20%He+0.05% CO2 Ar + 2%CO2 Ar + 1%O2 18-20 l/min
	1.0	120-200	24-28	
	1.2	140-220	24-28	
	1.6	180-260	24-30	

Ind.10



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