



# TIG 20/25CU

Old reference: TIG 385

## Classification

ISO 14343-A : W 20 25 5 Cu L  
AWS A5.9 : ER385

Material N° : 1.4519

## Description & Applications

Very low carbon content solid rod for TIG welding of totally austenitic stainless steels (Uranus B6\*, 904L...). Very good resistance to attacks by phosphoric and sulphuric acids. High resistance against pitting and stress corrosion in chloride containing media.

The TIG process is particularly suited for welding of piping systems, works of fine thinness equal or inferior than 3 mm and for penetration passes.

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## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	Cu	P	S	Fe
0.01	0.4	1.8	20.0	25.0	4.5	1.5	<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 )	
350	550	36	+20°C	120
			-196°C	80

## Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon / Nitrogen : 3-6 l/min

ind.10



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