



TIG 27/31CU

Old reference: TIG 383

Classification

AWS A5.9 : ER383

ISO 14343-A : W 27 31 4 Cu L

Description & Applications

Very low carbon content GTAW rod for joining of totally 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.

TIG welding is particularly recommended for piping systems, root penetration and for thin thickness plates.

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

Base materials

UNS	Aciers	EN 10088	N°d'alliage	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
0.01	0.15	1.8	27.0	31.0	3.5	1.0	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
350	550	35	+20°C 100

Welding Current & Instructions

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

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