

OK Autrod 385

A continuous solid corrosion resisting chromium-nickel-molybdenum-copper wire for welding of austenitic stainless alloys of 20% Cr, 25% Ni, 5% Mo, 1.5% Cu, low C types. OK Autrod 385 weld metal has a good resistance to stress corrosion and intergranular corrosion and shows a very good resistance to attack in non-oxidizing acids. The resistance and crevice corrosion is better than for ordinary 18% Cr, 8% Ni, Mo steels. The alloy is widely used in many applications related to the process industry.

Classifications Wire Electrode	SFA/AWS A5.9 : ER385 EN ISO 14343-A : G 20 25 5 Cu L
Approvals	VdTÜV 04905 (IT)

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Fully austenitic (20 % Cr - 25 % Ni - 5 % Mo - 1.5 % Cu - Low C)
Shielding Gas	I1, I2, I3, M13 (EN ISO 14175)

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	120 J (89 ft-lb)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	N
0.01	1.7	0.4	25.0	20.0	4.4	1.5	0.05

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (0.040 in.)	80-240 A	15-28 V	3.5-18.0 m/min (138-709 in./min)	1.5-6.0 kg/h (3.3-13. lb/h)
1.2 mm (0.047 in.)	100-300 A	15-29 V	3.0-14.0 m/min (118-551 in./min)	1.6-7.5 kg/h (3.5-16. lb/h)

Recommended Welding Parameters

Wire Diameter	Current	Voltage
0.8 mm (0.030 in.)	50-140 A	16-22 V
1.6 mm (1/16 in.)	230-350 A	24-28 V