



Supplier of Welding Alloys

Stainless Steel TIG, MIG and SUB-ARC Wire

Oxford Alloy® 385 (904L)

SPECIFICATIONS

AWS 5.9
ASME SFA 5.9

CLASSIFICATIONS

AWS ER385
UNS NO8904

DESCRIPTION / APPLICATION

Oxford Alloy ER385 (904L) is used for welding materials of similar chemical composition, which are used for fabrication of equipment and vessels for handling of sulfuric acid and many chloride containing media. This filler metal may also find applications for joining Type 317L material where improved corrosion resistance in specific media is needed. In order to reduce the propensity for fissuring and hot cracking, the low melting constituents such as carbon, silicon, and phosphorus are controlled to lower levels in this alloy.

AWS Chemical Composition						
C	Mn	Si	Cr	Ni	Cu	Mo
0.025 max	1.0- 2.5	0.50 max	19.5- 21.5	24.0- 26.0	1.2- 2.0	4.2- 5.2
S	P					
0.03 max	0.02 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 87,000 psi 600 MPa
Yield strength: 59,450 psi 410 MPa
Elongation: 36%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

Data contained in this publication are typical of the products and properties described, but are not suitable for specifications.
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