



Supplier of Welding Alloys

## Stainless Steel Coated Electrodes

### Oxford Alloy® 385-16 (904L)

**SPECIFICATIONS**

AWS 5.4  
ASME SFA 5.4

**CLASSIFICATIONS**

AWS E385-16  
UNS W88904

**DESCRIPTION / APPLICATION**

Oxford Alloy E385-16 is an electrode designed to run on direct current, reversed polarity as well as alternating current. This electrode gives a chromium-nickel-molybdenum weld metal with especially low carbon content and copper addition. Oxford Alloy E385-16 can be used for joining high alloyed, fully austenitic stainless steels such as W.-Nr. 1.4539 (ASTM B-625 and 904L), which have high corrosion resistance in sulphuric and phosphoric acids and good pitting resistance in acidic solutions containing chlorides and fluorides, such as seawater. This electrode can also be used for surfacing mild and low-alloyed steel to give protection against pitting corrosion in chloride containing solutions.

AWS Chemical Composition						
C	Cr	Ni	Mo	Mn	Si	P
0.03 max	19.5- 21.5	24.0- 26.0	4.2- 5.2	1.0- 2.5	0.9 max	0.03 max
S	Cu					
0.02 max	1.2- 2.0					

**TYPICAL MECHANICAL PROPERTIES**

Tensile strength: 88,000 psi 610 MPa

Yield strength: 65,500 psi 450 MPa

Elongation: 32%

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

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