



383 MCW

EN ISO 17633-A: T Z 27 31 4 Cu L M M12 1
AWS A5.9: EC383

DESCRIPTION

Metal cored stainless steel wire suitable for welding steels of similar composition and for dissimilar welds between these steels and mild steels, low alloyed and other stainless steels. Fully austenitic 27Cr-31Ni-4Mo, low carbon deposit. Resistant to stress corrosion cracking, crevice corrosion, pitting and intergranular corrosion.

WELDING POSITIONS



CURRENT

DC+

GAS

Ar/Co2(M12), Ar(I1)

BASE MATERIALS

G-X7 NiCrMoCuNb 25 20(1.4500), X5 NiCrMoCuNb 20 18(1.4505), X5 NiCrMoCuTi 20 18(1.4506), 904L(1.4539), 28(1.4563), 825(2.4858)

MECHANICAL PROPERTIES

<i>R_m</i> (Mpa)	<i>R_p 0,2</i> (Mpa)	<i>A5</i> (%)	<i>KV(j)</i>
620	430	40	-196°: 40

WELD METAL COMPOSITION(%)

C	Mn	Si	Cr	Ni	Mo	Cu	
0,025	1,5	0,3	27,0	31,0	4,0	1,3	

PACKAGING AND WELDING PARAMETERS

Dimension (mm)	1,2		
Volt (V)	17-38		
Ampere(A)	80-280		
Stick out (mm)	12-25		
Gas flow (l/min)	12-20		