

Applications

Used for welding of 20%Cr-25%Ni-4.5%Mo-1.5%Cu STS Steels.

Characteristics on Usage

- ① SMT-904L has a fully austenitic structure.
- ② Good general corrosion resistance, especially for sulphuric acid and phosphoric acid.
- ③ Preferably keep Heat input below 1.5KJ/mm.

Shielding Gas

Ar, Ar+He

Welding Current

GMAW: DC+(Pulse) GTAW : DC-

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu
0.013	0.31	1.89	0.013	0.001	20.52	24.96	4.32	1.42

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J(ft.lbs)	
			20°C (68°F)	-196°C (-321°F)
490 (71,000)	650 (94,300)	35.0	110 (81)	70 (52)

Approval

Packing

SMT-904L	Size mm (in)	1.0 (.039)	1.2 (.045)	1.6 (1/16)
	Weight	Spool : 12.5kg		
SMT-904L	Size mm (in)	2.0 (5/64)	2.4 (3/32)	3.2 (1/8)
	Weight	5kg* 1,000mm		