

LINCOLN® ER385

Stainless ▪ AWS ER385

KEY FEATURES

- Weld metal is fully austenitic and must be done with low heat input using a stringer bead technique
- Q2 Lot® - Certificate showing actual wire composition and calculated ferrite number (FN) available online
- Ink jet printing identification on entire length of electrode

WELDING POSITIONS

All

SHIELDING GAS

100% Argon

CONFORMANCES

AWS A5.9/A5.9M: ER385
ISO 14343: 2009: (20 25 5 Cu L)
ASME SFA-5.9: ER385

TYPICAL APPLICATIONS

- Pipeline segment
- Agitators
- Rotars
- Used in fabrication of equipment and vessels for handling and storage of sulfuric acid and phosphoric acid
- Used for welding materials of similar chemical composition (Type 904L)

DIAMETERS / PACKAGING

Diameter in (mm)	10 lb (4.5 kg) Tube 30 lb (13.6 kg) Master Carton
1/16 (1.6)	ED035240
3/32 (2.4)	ED035241

WIRE COMPOSITION⁽¹⁾ – As Required per AWS A5.9/A5.9M

	%C	%Cr	%Ni	%Mo	%Mn
Requirements AWS ER385	0.025 max	19.5 - 21.5	24.0 - 26.0	4.2 - 5.2	1.0 - 2.5
Typical Performance⁽²⁾	0.010	19.9	25.0	4.2	1.8
	%Si	%P	%S	%Cu	
Requirements AWS ER385	0.50 max	0.02 max	0.03 max	1.2 - 2.0	
Typical Performance⁽²⁾	0.3	0.01	0.001	1.4	

⁽¹⁾Typical all weld metal. ⁽²⁾See test results disclaimer

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

Fumes from the normal use of some welding products can contain significant quantities of components - such as chromium and manganese - which can lower the 5.0 mg/m³ maximum exposure guideline for general welding fume.

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.

INCOLOY® Filler Metal 65



INCOLOY Filler Metal 65 is used for gas-tungsten-arc welding of INCOLOY alloy 825 and other nickel-iron-chromium-molybdenum-copper alloys of similar composition. The weld metal is highly corrosion resistant, particularly in reducing chemicals such as sulphuric and phosphoric acids. INCOLOY Filler Metal 65 can also be used for depositing overlays on carbon and low alloys steels.

Specifications

AWS A5.14 ERNiFeCr-1 (UNS N08065)
 ASME II, Part C, SFA-5.14, ERNiFeCr-1 (UNS N08065)
 ASME IX, F-No.45
 *BS 2901 NA41
 *(EN) ISO 18274 – SNi8065 (NiFe30Cr21Mo3)
 *Supply to these specifications available upon request
 For manufacture to ASME III (NCA3800, NB2400), Rolls Royce, AMS and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

Ni+Co	38.0-46.0	Cr	19.5-23.5
C	0.05 max.	Al	0.20 max.
Mn	1.0 max.	Ti	0.60-1.20
Fe	22.0 min.	Mo	2.50-3.50
S	0.03 max.	P	0.03 max.
Si	0.50 max.	Others	0.50 max.
Cu	1.5-3.0		

Minimum Mechanical Properties

Tensile Strength, psi	80,000
MPa	552
Elongation, (4d) %	25

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

Available Product Forms

mm	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
in	0.030	0.035	0.040	0.045	0.047	0.062	0.093	0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)