



# Cromarod 385

SMAW - (Stick) - MMA  
Stainless Steel

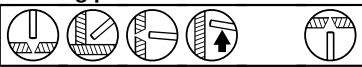
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### Description:

Cromarod 385 is a rutile flux coated electrode designed for welding the fully austenitic stainless steels of the 20%Cr / 25%Ni / 4.5%Mo / Cu type, used for their very high resistance to corrosion in severe, non-oxidising environments e.g. sulphuric acid. The low carbon, high alloy content of Cromarod 385 weld metal gives excellent resistance to intergranular corrosion and stress corrosion cracking, combined with superior resistance to crevice and pitting corrosion. Use no preheat, avoid high heat-input and maintain an interpass temperature of maximum 150 °C.

For very severe corrosion environments a special variant of this electrode, with a Mo content of 6%, is available to order.

### Welding positions:



### Coating type:

Rutile

### Welding current:

DC+, AC OCV > 39V

### Ferrite content:

FN 0 (WRC-92)

### Corrosion resistance

Very good resistance to general and intergranular corrosion in non-oxidising acid environments e.g. sulphuric (up to 90%), phosphoric and organic acids. Good resistance to stress corrosion in chloride bearing environments.

### Scaling temperature:

Approx. 1000 °C in air.

### Redrying temperature:

350 °C, 2h

### Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			1,0			19,0	24,0
Typical	0,02	0,8	1,1	0,02	0,02	20,5	25,5
Max	0,030	1,0	2,5	0,030	0,025	22,0	27,0

	Mo	Cu	V	Nb	N
Min	4,0	1,0			
Typical	4,2	1,5			
Max	7,0	2,0	0,1	0,1	0,250

### Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:	≥ 350 MPa	380 MPa
Tensile Strength, Rm:	≥ 560 MPa	580 MPa
Elongation, A5	≥ 30%	35%
Impact energy, CV:		20 °C • 55 J

### Classification:

AWS A5.4 ~E 385-17  
ISO 3581-A E 20 25 5 Cu N L R 12

### Approvals:

CE

### Note

AWS: Slight deviation in Si

Core wire:  
P ≤ 0.020%  
S ≤ 0.015%  
N ≤ 0.08%

### Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/ kg electrodes	No. of electrodes/ kg weld metal	Kg weld metal/ hour arc time	Burn-off time/ electrode (sec.)
2,5	300	74502500	40-80	24	0,53	101	1,1	33
3,2	350	74503200	80-120	25	0,58	50	1,5	48
4,0	350	74504000	130-170	26	0,58	33	2,3	48

