OK Autrod 385

A continous solid corrosion resisting chromium-nickel-molybdenum-copper wire for welding of austenitic stainless alloys of 20% Cr, 25% Ni, 5% Mo, 1,5% Cu, low C types.
OK Autrod 385 weld metal has a good resistance to stress corrosion and intergranular corrosion and shows a very good resistance to attack in non-oxidizing acids. The resistance and crevice corrosion is better than for ordinary 18% Cr, 8% Ni, Mo steels. The alloy is widely used in many applications related to the process industry. OK Autrod 385 can be used in combination with OK Flux 10.93.

Classifications Wire Electrode	SFA/AWS A5.9 : ER385 EN ISO 14343-A : S 20 25 5 Cu L
Approvals	VdTÜV 12101

Approvals are based on factory location. Please contact ESAB for more information.

Alloy Type	Fully austenitic (20 % Cr - 25 % Ni - 5 % Mo - 1.5 % Cu - Low C)

Typical Wire Composition %

C	Mn	Si	Ni	Cr	Mo	Cu	N
0.01	1.7	0.4	25.0	20.0	4.4	1.5	0.05

411040-en_US-FactSheet_Main-01 2022-01-17