Data sheet and application

DIM L-1.3954 ©

Material no.: 1.3954
DIN 8556: SG-X 2 CrNiMnMoN 22 17 8 4
EN ISO 14343-A: GZ 22 17 8 4 N L

Non-magnetic, highly alloyed, highly corrosion-resistant

Characteristics

The N2-alloyed, fully austenitic and non-magnetic solid wire electrode is distinguished by its particularly good resistance to pitting, gap and stress corrosion cracking. Very good low-temperature toughness, can be used up to + 350 ° C or + 400 ° C for media which do not cause intercrystalline corrosion. Use for seawater desalination plants, centrifuges, bleaching plants and in special shipbuilding, as well as for the welding of cold-steels, e.g. X8Ni9.

Materials

1.3948 X4CrNiMnMoN19-13-8, 1.3951 X2CrNiMoN22-15,
1.3952 X2CrNiMoN18-14-3, 1.3953 X2CrNiMo18-15,
1.3964 X2CrNiMnMoNNb21-16-5-3, 1.4439 X2CrNiMoN17-13-5

Chemical composition

C	Si	Mn	Cr	Ni	Mo	N	PREN
0,02	0,63	7,3	22,2	17,7	3,7	0,23	37

Certificate of batch upon request.

Mechanical properties of pure weld metal

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Yield strength Rp0.2 MPa	Tensile strength Rm MPa	Elongation A (L0=5d0) %	Impact energy ISO-V KV J +20°C | -196°C
440 (≥ 430)	680 (≥ 640)	32 (≥ 30)	120 (≥ 70) | (≥ 32)

* untreated, welding state - protective gas Ar + 20% He + 0.5% CO2

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Processing instructions

Protection gases: Argon + 20-30% He + max. 2% CO2 / argon + 20% He + 0.5% CO2

Approvals and suitability tests

GL, BWB