

## MT-904 L

## 1.4519

TIG/MIG welding wire of fully austenitic, copper-containing chrome-nickel-molybdenum-steel with high molybdenum and very low carbon content, for welding high-alloy steels which are strongly corrosion resistant when exposed to reducing media. Weld metal suitable for temperatures up to +350°C.

### Standard designation

Material No.	1.4519
AWS/ASME SFA-5.9	ER 385
EN ISO 14343-A	G/W 20 25 5 Cu L

### Main base metals

Exceptionally corrosion-proof steels/cast steels e.g.

1.4500	G-X 7 NiCrMoCuNb 25 20	1.4536	G-X 2NiCrMoCuN 25 20
1.4505	X 5 NiCrMoCuNb 20 18	1.4539	X 2 NiCrMoCu 25 20 5
1.4506	X 5 NiCrMoCuTi 20 18	1.4585	G-X 7 NiCrMoCuNb 18 18

### Mechanical properties of all – weld – metal (typical values)

Welding process			TIG I1		MIG M12	
Gas shield			untreated		untreated	
Thermal treatment			+20° - 196°C		+20°C -196°C	
Test temperature			[°C]		[°C]	
0,2%-yield strength	R <sub>p0,2</sub>	MPa	≥320		≥320	
Tensile strength	R <sub>m</sub>	MPa	≥510		≥510	
Elongation	A <sub>5</sub>	[%]	≥25		≥25	
Impact strength	A <sub>v</sub>	[J]	LNB	LNB	LNB	LNB

### Average chemical composition of all - weld – metal (%)

C	Si	Mn	Cr	Mo	Ni	Cu
0,03	1,0	1,0-4,0	19,0-22,0	4,0-6,0	24,0-27,0	1,0-2,0

### Structure

Fully austenitic

### Approvals

TÜV, DB, CE

### Gas types applicable TIG

I1

### Gas types applicable MIG

M 12

### TIG rod diameters, unit weights

Diameter [mm]	Length [mm]	Kg per box
1,60	1000	10,0
2,00	1000	10,0
2,40	1000	10,0
3,20	1000	10,0

### MIG welding wire

Diameter                      0,8mm                      1,0mm                      1,2mm

### Welding positions MIG acc.to EN ISO 6947

PA, PB, PF

### Welding positions TIG acc.to EN ISO 6947

PA, PB, PC, PF

### Current/Polarity TIG

= -

### Current/Polarity MIG

= +