

MIDALLOY ER385 BARE WIRE

CLASSIFICATION

- AWS 5.9 Class ER385 / ASME SFA 5.9 Class ER385

DESCRIPTION

- MIDALLOY ER385 stainless steel wire is used for GMAW and GTAW welding.

APPLICATIONS

- MIDALLOY ER385 is used to weld metals with similar composition; such as 904L (UNS N08904), in wrought and cast forms. This product is vacuum melted to reduce levels of carbon, phosphorus, and sulfur to reduce micro-fissuring.

TYPICAL CHEMISTRY

C	Si	Mn	P	Cr
.015	.48	1.85	.015	20.5
S	N	Mo	Cu	Ni
.010	<0.60	4.8	1.50	25.0

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	78,000 PSI
YIELD STRENGTH	47,500 PSI
ELONGATION IN 2"	35%

RECOMMENDED WELDING PARAMETERS

PROCESS	DIAMETER	VOLTAGE	AMPERAGE	GAS/FLUX
TIG (GTAW)	1/16"	14-18	90-130	100% Ar
	3/32"	15-20	120-175	100% Ar
	1/8"	15-20	150-220	100% Ar
MIG (GMAW)	.035" SHORT ARC	16-26	70-160	69%Ar-30%He-1%O ₂
	.035" SPRAY ARC	26-31	150-230	92%Ar-8%Co ₂ or
	.045" SPRAY ARC	28-32	180-280	98%Ar-2%O ₂
SUB-ARC (SAW)	3/32"	28-30	275-350	Record IN
	1/8"	29-32	350-450	Record IN

PACKAGING

- TIG 10 lb. tube/60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

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