

MIG & TIG

Oxford Alloy® 385

AWS ER385 • Stainless Steel

Key Features

- ❖ For welding materials of similar chemical composition (Type 904L).
- ❖ Used in fabrication of equipment and vessels for handling and storage of sulfuric acid and phosphoric acid.
- ❖ The weld metal is fully austenitic, and must be done with low heat input, using a stringer bead technique.

Conformances

AWS/ASME SFA 5.9

ER385

UNS N08904

Chemical Composition - As required per AWS 5.9

C	Mn	Si	Cr	Ni	Cu	Mo
0.025 max	1.0-2.5	0.50 max	19.5-21.5	24.0-26.0	1.2-2.0	4.2-5.2
S	P					
0.03 max	0.02 max					

Mechanical Properties - As required by AWS 5.9

	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %
AWS Requirements	Not Specified		
Typical Results - As welded	600 (87)	410 (59)	36



Typical Welding Parameters

Diameter		Process	Volt	Amps	Shielding Gas
in	(mm)				
.035	0.9	GMAW	22-23	180-210	Spray Transfer 98% Argon / 2% Oxygen
.045	1.2	GMAW	23-25	195-260	
1/16	1.6	GMAW	25-28	260-390	
.035	0.9	GMAW	19-23	55-170	Short Circuiting Transfer 90% Helium / 7 1/2 % Argon / 2 1/2 CO ₂
.045	1.2	GMAW	19-23	100-185	
1/16	1.6	GMAW			
1/16	1.6	GTAW	14-18	90-130	100% Argon
3/32	2.4	GTAW	15-20	120-175	100% Argon
1/8	3.2	GTAW	15-20	150-220	100% Argon

Diameters & Packaging

Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Form	Packaging (lbs)	Diameter (mm)	Form	Packaging (kgs)
.035	GMAW	33 lb spool 1980 lb pallet	0.9	GMAW	15 kg spool 900 kg pallet
.045	GMAW	33 lb spool 1980 lb pallet	1.2	GMAW	15 kg spool 900 kg pallet
1/16	GMAW	33 lb spool 1980 lb pallet	1.6	GMAW	15 kg spool 900 kg pallet
1/16	GTAW	10 lb tube 40 lb carton	1.6	GTAW	5 kg tube 20 kg carton
3/32	GTAW	10 lb tube 40 lb carton	2.4	GTAW	5 kg tube 20 kg carton
1/8	GTAW	10 lb tube 40 lb carton	3.2	GTAW	5 kg tube 20 kg carton

Actual test results may vary. Refer test result disclaimer on page 160.