

## Classifications

EN ISO 14343-A

W Z22 17 8 4 N L

## Characteristics and typical fields of application

GTAW rod, N-alloyed, fully austenitic and nonmagnetic, special is distinguished by its especially high resistance to pitting, crevice corrosion and stress corrosion cracking. Excellent cryogenic toughness.

Suitable for service temperatures up to +350 °C, and up to +400 °C in media that do not induce intergranular corrosion. Used for sea water desalination plants, centrifuges, bleaching plants and in special shipbuilding.

## Base 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

## Typical analysis of the TIG rods (wt.-%)

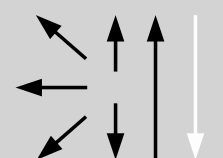
	C	Si	Mn	Cr	Ni	Mo	N		PRE <sub>N</sub>
wt.-%	0.02	0.65	7.5	22.0	17.0	3.7	0.23		36.9

## Mechanical properties of all-weld metal

Condition	Yield strength R <sub>p0,2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J	
	MPa	MPa	%	+20 °C	-196 °C
u	<b>480</b> (≥ 430)	<b>690</b> (≥ 640)	<b>35</b> (≥ 30)	<b>130</b> (≥ 70)	≥ 32

u untreated, as welded – shielding gas Argon

## Operating data

	<b>Polarity</b> DC (-)	<b>Shielding gas:</b> 100 % Argon	<b>Rod marking:</b> front: ✦ W Z 22 17 8 4 NL back: 1.3954	<b>ø (mm)</b> 2.0
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Preheating of the base metal is not required. The interpass temperature should not exceed 150 °C.

## Approvals

WIWEB, GL (3954), CE