



D&H 385

CODIFICATION: AWS : SFA 5.4 E385-16

CHARACTERISTICS AND APPLICATIONS :

D&H 385 is a non-synthetic rutile coated stainless steel electrode depositing a weld metal containing low carbon 20Cr - 25Ni - 5Mo - 2Cu which exhibits excellent resistance to corrosion in non oxidizing media like sulfuric acid, phosphoric acid, acetic acid, formic acid, fatty acids, oxalic acid etc.

● Soft and stable arc, which is easy to strike and re-strike. ● Low spatter. ● Smooth weld beads. ● Easy slag detachability.

It is ideally suited for welding materials for application where phosphoric, sulfuric acids, and other non-oxidizing solutions are encountered. The addition of Mo and Cu in the weld metal helps in resisting corrosive attack of these solutions. It is particularly suited for welding Carpenter 20, HV9, HV9A, Uranus B6, UHB 904L, Sandvik 2RR65, and similar materials which are used for these service conditions.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

| Element | C | Mn | Si | Cr | Ni | Mo | Cu | S | P |
|---------|---------|-----|------|------|------|-----|------|-------|-------|
| Percent | : 0.030 | 2.0 | 0.40 | 20.0 | 24.0 | 4.4 | 1.80 | 0.012 | 0.020 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

| | |
|--------------|-------------------------|
| UTS (MPa) | Elongation (L = 4d)% |
| 545 | 32.0 |

CURRENT AND PACKING DATA : AC/DC(+)

| | | | | |
|-------------------------|-----------|---------|----------|---------|
| Size (mm) | : 5x350 | 4x350 | 3.15x350 | 2.5x350 |
| Dia x Length | | | | |
| Current Range (Amps) | : 140-180 | 110-140 | 80-100 | 60-80 |
| Weight/Carton (kgs) | : 2.5 | 2.5 | 2.5 | 2.5 |

PRECAUTIONS :

1. The electrodes should be kept dry. In case of moisture pick-up re-dry the electrodes at 250-300°C for one hour.
2. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input.

Note: D&H 385-15 conforming to AWS E385-15 is also available.