

## COR™STAIN 904L FC

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### DESCRIPTION

COR™STAIN 904L FC is a flux-cored, super austenitic stainless steel wire formulated to weld in the flat position. The arc action is a smooth, globular transfer, and the slag is easily removed. The resulting weld deposit exhibits excellent corrosion resistance.

### APPLICATIONS

904L FC is used to weld 904L and overlay steel intended for severe corrosion in various process industries. The high moly content ensures extended resistance to pitting and crevice corrosion.

### PROCEDURE

Minimize preheat and interpass temperature.

### WELDING PARAMETERS

	Size	Volts	Amps	Stickout	Shielding Gas
FC-O	.045"	24-28	120-200	1"	
FC-O	1/16"	25-30	150-250	1.25"	
FC-G	.045"	24-28	120-200	0.5"	100% CO <sub>2</sub> or 75Ar-25 CO <sub>2</sub>
FC-G	1/16"	25-30	150-250	0.5"	100% CO <sub>2</sub> or 75Ar-25 CO <sub>2</sub>
MC-G	.045"	Pulsed power source, high Argon shielding gas			
MC-G	1/16"	Pulsed power source, high Argon shielding gas			

### MECHANICAL PROPERTIES

Tensile Strength: 75,000 psi minimum  
 Elongation: 30% minimum

### CLASSIFICATION

Chemistry and properties conform to: AWS A5.4, class E385-XX