

TECHNICAL DATA

Standards

DIN Material Nr. 1.4519

EN ISO 14343-A :	G 20 25 5 Cu L
AWS A5.9 :	ER385

General Properties / Field of Applications

DSI M Connect 4 is a Laser Welding Wire for highly corrosion-resistant joints and coatings on similar austenitic CrNiMoCu steels, castings and for similar CrNiMo steels. Fully austenitic wire with a pronounced resistance to pitting and crevice corrosion in chloride-containing media. High resistance to sulphuric, phosphoric, acetic and formic acid, sea and brackish water. Very good resistance to stress corrosion cracking due to the high Ni content.

Mechanical Properties

Yield strength $R_{p0.2}$	[MPa] / [N/mm ²]	420
Tensile strength R_m	[MPa] / [N/mm ²]	650
Elongation A ($L_0 = 5d_0$)	[%]	38
Impact Work KV	[J]	120 at +20°C

Chemical Composition (Standard Values in %)

C	Si	Mn	Cr	Ni	Mo	Cu
0.01	0.4	1.8	20.0	25.0	4.3	1.4

Compatible Materials (Selection)

1.4539 X1NiCrMoCu25-20-5 / 1.4537 X1CrNiMoCuN25-25-5 / 1.4438 X2CrNiMo18-15-4
ASTM A 182 Gr. F317L, F904L / A 213 Gr. TP317L / A 312 Gr. TP317L
A 403 Gr. WP317L / A 813 Gr. TP317L / A 988 Gr. UNS 31307

Packaging and available Sizes*

Spool : MA125 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2
Rod : 500 / 1000 mm	Ø mm	0.2 / 0.3 / 0.4 / 0.5 / 0.6 / 0.7 / 0.8 / 1.0 / 1.2

* Other dimensions available on request

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