

FCAW

DW-N709SP

PREMIARC™

Flux cored wire

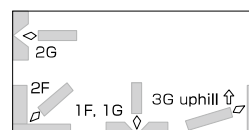
Features: ▪ Hastelloy type consumable
 ▪ Suitable for 9%Ni steel

Classification: AWS A5.34 ENiMo13T1-1/4

Shielding gas: CO₂ or Ar-CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (wire mass%)

	Typical (Ar-CO ₂)	Guaranty ^a
C	0.01	0.10
Si	0.12	0.75
Mn	2.4	2.0~3.0
P	0.012	0.020
S	0.003	0.015
Ni	63.4	58.0min.
Cr	6.7	4.0~8.0
Mo	17.5	16.0~19.0
Cu	<0.1	0.5
Fe	6.8	10.0
W	2.6	2.0~4.0

Note: ^aSingle values are maximum, except Ni.

Welding parameters (A)

φ mm	1F, 1G, 2F	2G	3G uphill
1.2	180~250	150~210	140~180

All-weld mechanical properties

	Typical (Ar-CO ₂)	Guaranty
0.2%YS (MPa)	440	-
TS (MPa)	712	690min.
EI on 4d (%)	43	25min.
IV -196°C (J)	77	-

Approvals

ABS	MG
LR	9NiS
DNV-GL	MS (9Ni)
BV	ISO 12513 T Ni 1013 P M21 2
NK	KMWL92G (C), KMWL92G (C) -YP430M-TS690M(CO ₂)
CCS	9Ni (Ar-CO ₂)