

FCAW

DW-N625

PREMIARC™

Flux cored wire

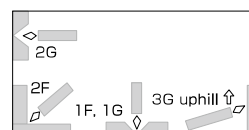
Features: ▪ Suitable for Ni-based alloy of 625, dissimilar-metal joints and overlaying

Classification: AWS A5.34 ENiCrMo3T1-1/4

Shielding gas: Ar-CO₂, CO₂

Polarity: DCEP

Welding Positions:



Packaging data

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

Composition (all-weld metal mass%)

	Typical (Ar-CO ₂)	Guaranty ^a
C	0.03	0.10
Si	0.37	0.50
Mn	0.28	0.50
P	0.01	0.02
S	0.003	0.015
Ni	63.3	58.0min.
Cr	21.6	20.0~23.0
Mo	8.6	8.0~10.0
Cu	0.01	0.50
Fe	1.8	5.0
Nb+Ta	3.57	3.15~4.15
Ti	0.11	0.40

Note: ^aSingle values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill
1.2	150~210	130~180

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	472	-
TS (MPa)	752	690min.
El on 4d (%)	38	25min.
IV 0°C (J)	67	-

Approvals

ABS	MG
BV	UP (ENiCrMo3T1-4)

Note: Ar-CO₂