

FCAW

DW-NC276

PREMIARC™

Flux cored wire

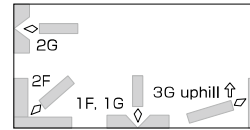
Features: ■ Suitable for Ni-based alloy of C276 and super austenitic stainless steel

Classification: AWS A5.34 ENiCrMo4T1-4

Shielding gas: Ar-CO₂

Polarity: DCEP

Welding Positions:



Packaging data

| φ mm | Spool | |
|-----------|------------------|--------|
| 1.2 | 12.5kg | 12.7kg |
| Volume mm | 295W, 110H, 295L | |

Composition (all-weld metal mass%)

| | Typical | Guaranty ^a |
|-----------|---------|-----------------------|
| C | 0.02 | 0.02 |
| Si | 0.2 | 0.2 |
| Mn | 0.6 | 1.0 |
| P | 0.01 | 0.03 |
| S | <0.01 | 0.03 |
| Ni | 57.3 | Bal. |
| Cr | 14.8 | 14.5~16.5 |
| Mo | 16.9 | 15.0~17.0 |
| Cu | 0.07 | 0.50 |
| Fe | 5.6 | 4.0~7.0 |
| W | 3.7 | 3.0~4.5 |
| Co | 0.3 | 2.5 |
| V | 0.06 | 0.35 |

Note: ^a Single values are maximum.

Welding parameters (A)

| φ mm | 1F, 1G, 2F |
|------|------------|
| 1.2 | 150~220 |

All-weld mechanical properties

| | Typical | Guaranty |
|---------------------|---------|----------|
| 0.2%YS (MPa) | 466 | - |
| TS (MPa) | 719 | 690min. |
| EI on 4d (%) | 46 | 25min. |
| IV 0°C (J) | 63 | - |