

FCAW

DW-N82

PREMIARC™

Flux cored wire

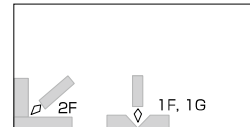
Features: ■ Suitable for Ni-based alloy of 600 and dissimilar-metal joints such as Ni-based alloy to low alloy steel and stainless steel to low alloy steel

Classification: AWS A5.34 ENiCr3T1-4

Shielding gas: Ar-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	Guaranty ^a
C	0.02	0.10
Si	0.20	0.50
Mn	3.0	2.5-3.5
P	<0.01	0.03
S	0.003	0.015
Ni	71.4	67.0min.
Cr	21.1	18.0~22.0
Cu	<0.01	0.50
Fe	0.8	3.0
Nb+Ta	2.5	2.0~3.0
Ti	0.17	0.75

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)	380	-
TS (MPa)	650	552min.
EI on 4d (%)	46	25min.
IV 0°C (J)	128	-