PREMIARC™

DW-329A

80%Ar - 20%CO_2
EN ISO 17633-A T 22 9 3 N L R M21 3
AWS A5.22 E2209T0-4
EN 1.4462

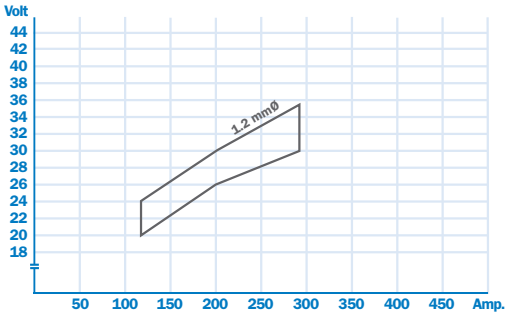
Description and Application

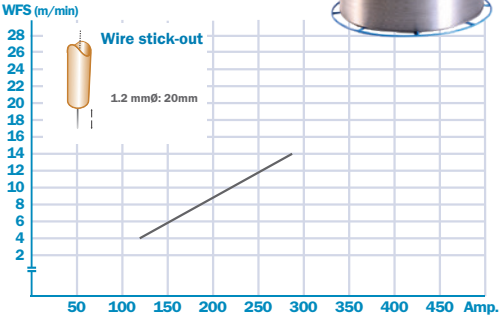
This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces.

This wire is designed for welding duplex stainless steel such as AISI S31803 or EN 1.4462 stainless steels.

Due to the high nitrogen and high molybdenum content in the weld metal, it is possible to obtain excellent resistance to chloride induced pitting corrosion.

Recommended Parameter Range, for flat position*





Typical Chemical Analysis (wt. %)*

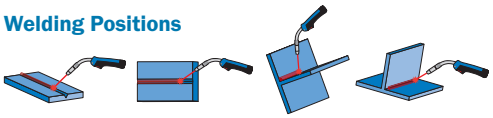
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FNW
0.03	0.75	0.97	0.019	0.006	9.3	23.3	3.4	0.14	-	49.0

Typical Mechanical Properties*

	R_e(MPa)	R_m(MPa)	A_5(%)	CV(J)-20°C	CV(J)-46°C
	656	850	29	49	43
Guaranty	min.450	min.690	min.20		

* The above values and parameters are for all weld metal produced using Ar+CO_2 shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
S31803	S31803	SA2205	-	-	TÜV, RINA