KOBELCO

PREMIARC™ DW-N625

Ni base alloy rutile flux cored wire for all position welding
AWS A5.34 ENiCrMo3T1-4
EN ISO 12153 T Ni 6625 P M21 2

Features and typical fields of application

- PREMIARC™ DW-N625 is a gas shielded flux cored wire whose chemical design is optimized to weld 625, 825 type Ni-Cr-Mo alloy, full austenitic stainless steel or dissimilar joints with carbon steel.
- Featuring outstanding weldability for all position with excellent mechanical properties for welded joints as well as overlay use with 75-80%Ar-bal.CO_2 shielding gas.

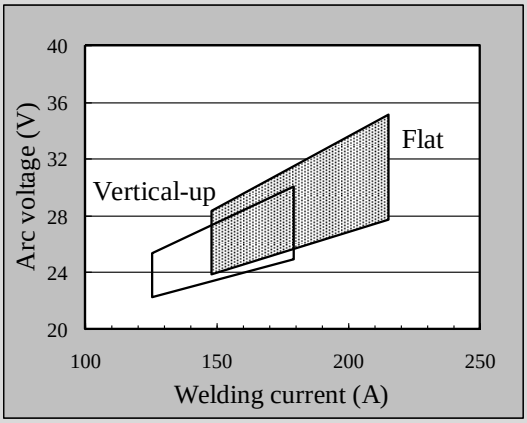

Figure: Welding parameter recommendation

Typical chemical composition of all weld metal per AWS A5.34 w/80%Ar-20%CO_2

	C	Si	Mn	P	S	Cu
DW-N625	0.030	0.36	0.41	0.008	0.002	0.01
	Ni	Mo	Ti	Fe	Nb	Others
DW-N625	60.8	21.6	0.16	4.1	3.4	-

Typical mechanical properties of all weld metal per AWS A5.34 w/80%Ar-20%CO_2

	0.2% P.S.(psi)	T.S. (psi)	EL. (%)	CVN (ft-Lbs)		
				-320°F	-150°F	32°F
DW-N625	58,450	56,130	38	38	46	49
ENiCrMo3T*x-y*	N/A	100,000 min.	25 min.	N/A	N/A	N/A

Packages

Wire Dia.	0.045”	Package	28lbs plastic spool

DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.

WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

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