

Description and Application

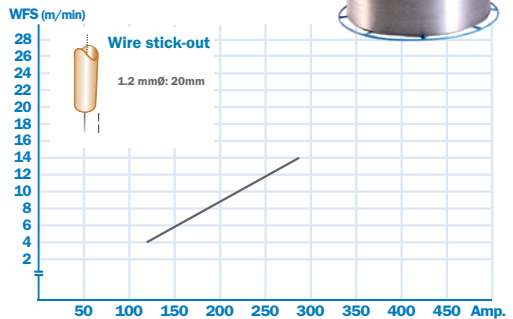
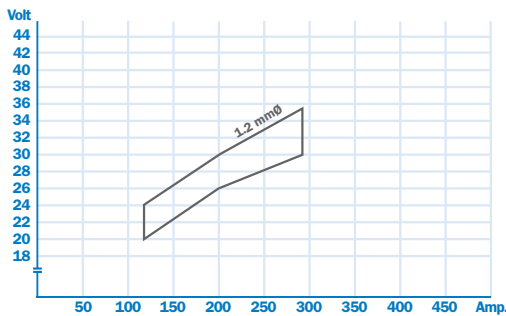
This wire is a rutile flux cored wire which operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self releasing slag.

This wire deposits low carbon weld with 24%Cr-13%Ni and Niobium to minimize the risk of sensitization. It is suitable for the first layer on mild or low alloy steel prior to overlaying with **DW-347** or **DW-347H**.

This wire is also popular for petrochemical reactors when completing cladding.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

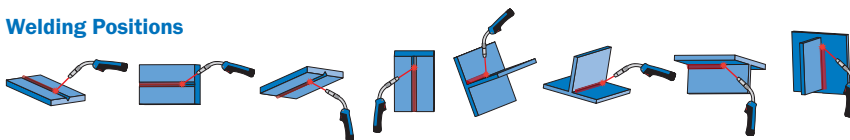
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.58	1.02	0.013	0.003	12.7	24.3	-	-	0.9	16	>18	25

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)+20°C	CV(J)0°C
Guaranty	511	689	33	84	79
	-	min.520	min.30	-	-

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-