

Description and Application

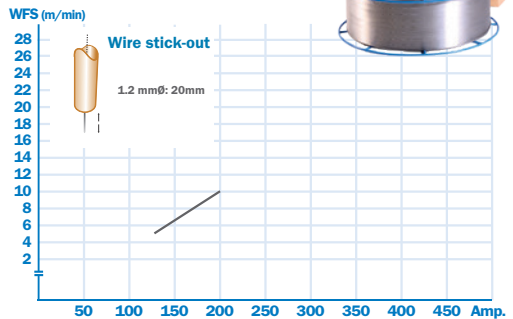
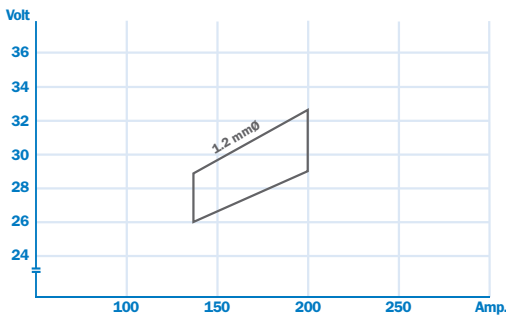
DW-N625P is a nickel based flux cored wire for welding nickel alloys 625, 825 and super austenitic stainless steels.

DW-N625P is an ideal wire for circumferential joining of pipes including clad pipes in fixed positions. Excellent bead wetting, very stable arc, little spatter and easy slag removal on circumferential joining of pipes can be obtained by both fully automated and manual welding.

For circumferential welding of pipes in fixed position, DW-N625P offers better weld metal soundness when compared with conventional 625 type FCW's. DW-N625P still retains the advantage of much higher productivity when compared with traditional SMAW, GTAW and GSAW (MIG).



Recommended Parameter Range, for flat position



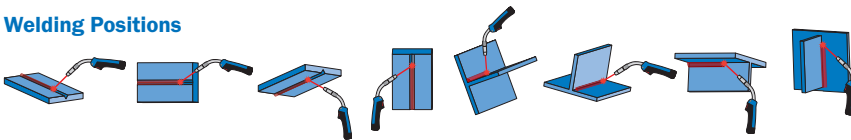
Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Fe	Nb+Ta	Ti	Co	W	V
0.030	0.21	0.02	0.007	0.004	0.010	65.2	21.1	8.8	1.7	3.23	0.17	-	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)0°C	CV(J)-100°C	CV(J)-196°C
Guaranty	479	765	45	84	78	70
	min.420	min.690	min.25			

Welding Positions



Approvals

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