

80%Ar - 20%CO₂

EN ISO 17633-A-T 19 12 3 Nb P M 2

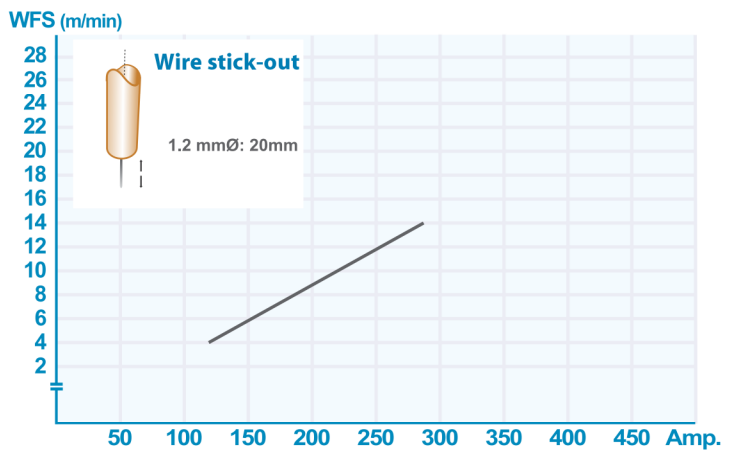
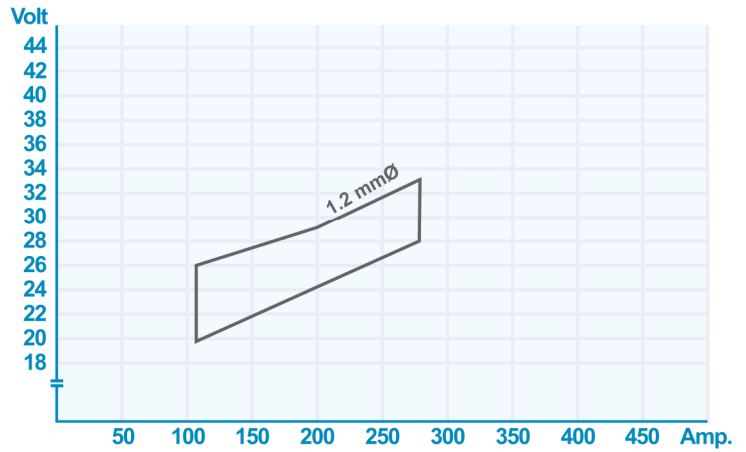
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Description and Application

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

PREMIARC™ DW-318 is designed for welding 18%Cr-12%Ni-2%Mo-Nb or Ti stainless steel. Due to its Mo and Nb content, DW-318 provides good resistance against intergranular corrosion and non-oxidizing acid.

Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.50	1.30	0.02	0.012	11.6	18.5	2.8	-	0.4	8.9	16.0	12.9

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J)	°C
	511	680	31	57	0
Guarantee	min.350	min.550	min.25		

Welding Positions



Approvals

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