

PREMIARC™ DW-N625

80%Ar - 20%CO₂
 EN ISO 12153 T Ni 6625 P M 2
 AWS A5.34 ENiCrMo3T1-4
 2.4831

Description and Application

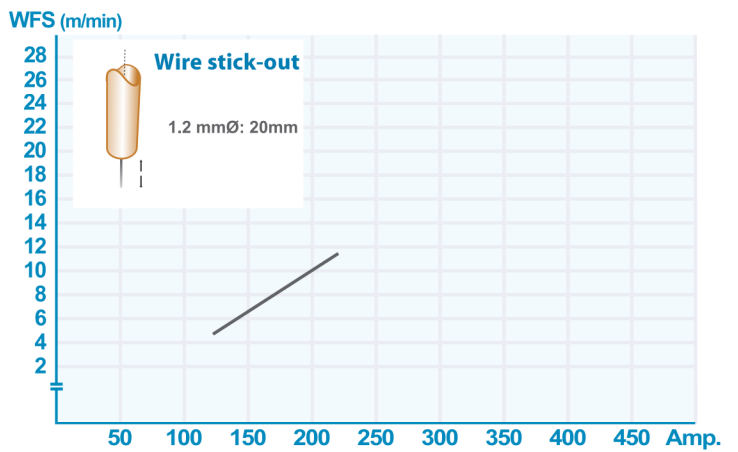
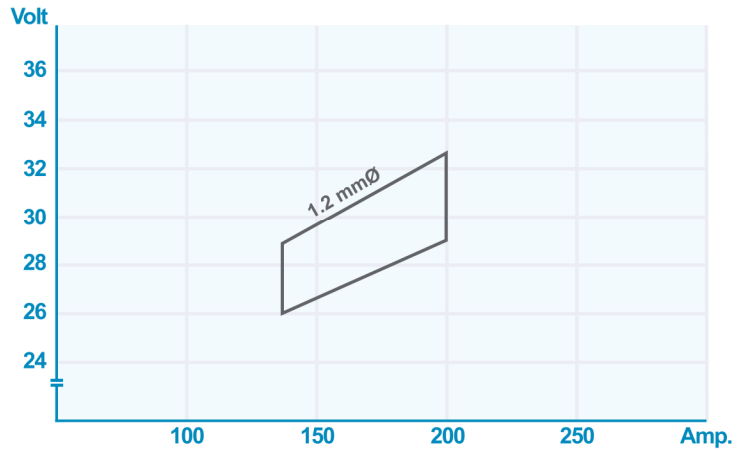
PREMIARC™ DW-N625 is a nickel based flux cored wire for welding nickel based alloys 625, 825 and also super austenitic stainless steels.

PREMIARC™ DW-N625 has a stable arc with minimal spatter, which makes it also an excellent product for welding in all positions.

This wire is recommended for a wide variety of applications, including overlay welding of carbon steel or low alloy steels and a wide variety of dissimilar metal joints.

Please note that for circumferential joining of pipes in fixed positions, DW-N625P is a better choice than DW-N625.

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
0.028	0.38	0.36	0.006	0.003	0.010	63.3	21.6	8.5	2.1	3.45	0.16	-	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV (J) 0°C	CV (J) -100°C	CV (J) -196°C
	472	752	38	67	63	52
Guarantee	min.420	min.690	min.25			

Welding Positions



Approvals

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