

**KOBELCO****Nickel based alloy flux cored wires****PREMIARC™****PREMIARC™****DW-N625****DW-NC276****AWS A5.34 ENiCrMo3T1-4****AWS A5.34 ENiCrMo4T1-4****Outstanding Features**

- DW-N625 is a flux cored wire for alloy 625, 825 and super austenitic stainless steel.
- DW-NC276 is a flux cored wire for alloy C276 and super austenitic stainless steel.
- These wires generate a stable arc with little spatter, suitable for all positions with 75%Ar-25%CO<sub>2</sub>.
- These wires are recommended for a variety of welding applications including overlay welding of carbon steels or low alloy steels and a wide variety of dissimilar joints.

**Typical chemistry of weld metal (75%Ar-25%CO<sub>2</sub>)**

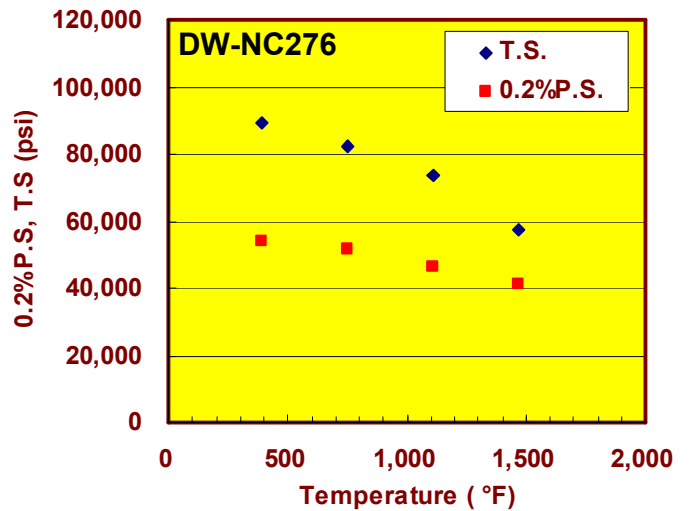
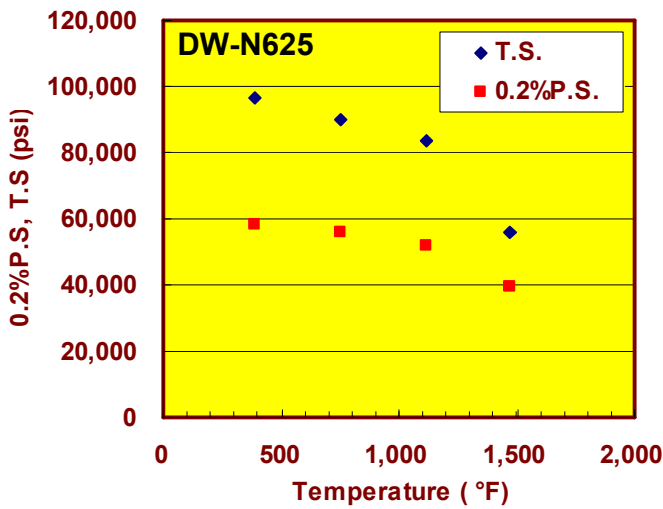
Wire	C	Mn	Fe	P	S	Si	Cu	Ni
DW-N625	0.030	0.41	4.1	0.008	0.002	0.36	0.01	60.8
DW-NC276	0.018	0.74	6.2	0.009	0.004	0.16	0.06	57.5

Wire	Co	Ti	Cr	Nb+Ta	Mo	V	W
DW-N625	-	0.16	21.6	3.4	9.1	-	-
DW-NC276	0.02	-	15.5	-	15.9	0.02	3.6

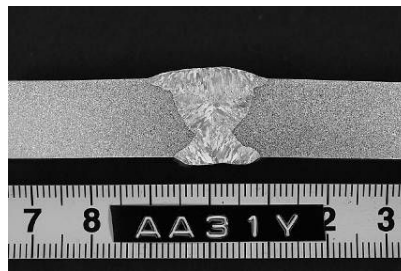
**Typical mechanical property of weld metal (75%Ar-25%CO<sub>2</sub>)**

Wire	0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)		
				-320 °F	-150 °F	32 °F
DW-N625	68,400	109,000	38	38	46	49
DW-NC276	66,600	104,400	48	39	43	49

Test method: AWS A5.34, welding parameter: 180-200A/29-30V (0.045")

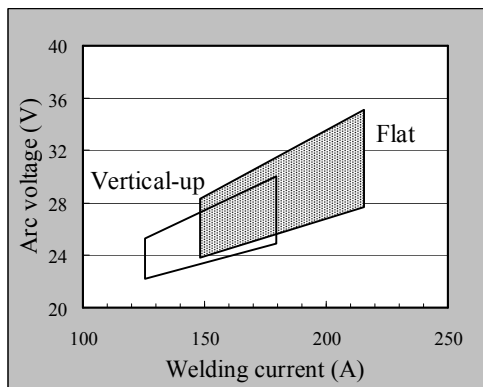


**Tensile properties at high temperatures**

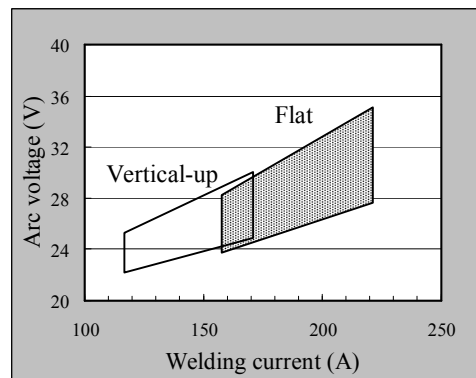


Base material:  
 Alloy 825  
 Wall thickness: 15/32"  
 Welding parameter:  
 160A/26-27V  
 Shielding gas:  
 75%Ar-25%CO<sub>2</sub>

**Bead appearance and macrostructure of butt joint for DW-N625 (3G)**



**DW-N625**



**DW-NC276**

**Recommended welding parameters (75%Ar-25%CO<sub>2</sub>)**