

KOBELCO

PREMIARC™

DW-2101

All positional flux cored wire for LDX 2101® stainless



New generation

Outstanding Features

- DW-2101 is designed for welding the lean duplex stainless steel LDX 2101®.
- Excellent weldability not only in flat and horizontal but in vertical upward welding.
- DW-2101 has the option of being shielded by 75%Ar-25%CO₂ gas mixture or 100%CO₂ gas (Mixture gas is preferable).
- DW-2101 provides a smooth bead appearance, minimal spattering and slag is easily removable.

*LDX2101® has registered trade name by Outokumpu

Typical chemistry of weld metal (75%Ar-25%CO₂)

C	Si	Mn	Cr	Ni	Mo	Cu	N	PRE	FN
0.03	0.70	1.50	24.7	8.1	<0.1	0.02	0.13	26.8	47

PRE=Cr+3.3×Mo+16×N, FN=Ferrite Number by WRC Diagram(1992)

Typical mechanical property of weld metal (75%Ar-25%CO₂)

0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)	
			-40 °F	68 °F
86,400	109,600	29	27 <17>	36 <27>

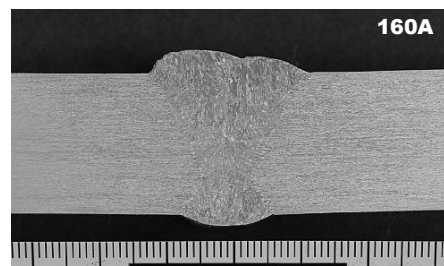
Test method: AWS A5.22, welding parameter: 200A-28V (0.045")

< >: Lateral expansion (unit=mils)

Macrostructure of butt joint (2G)



Macrostructure of butt joint (3G)



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