

KOBELCO**Nickel based alloy flux cored wires****PREMIARC™****DW-N625****AWS A5.34 ENiCrMo3T1-4****PREMIARC™****DW-NC276****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%CO₂.
- 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%CO₂)

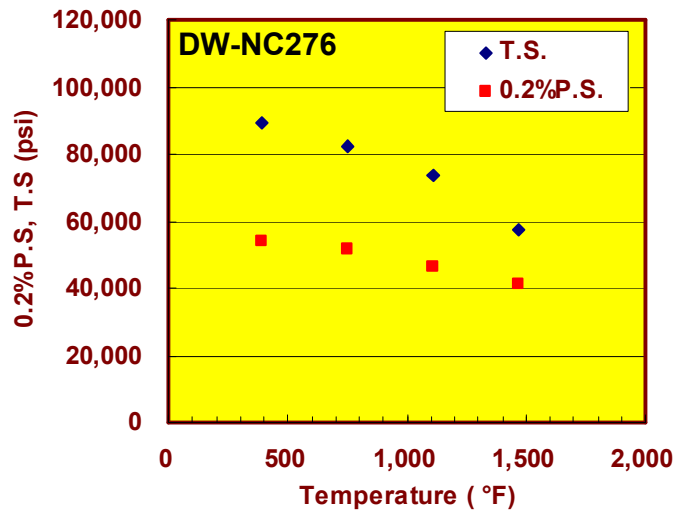
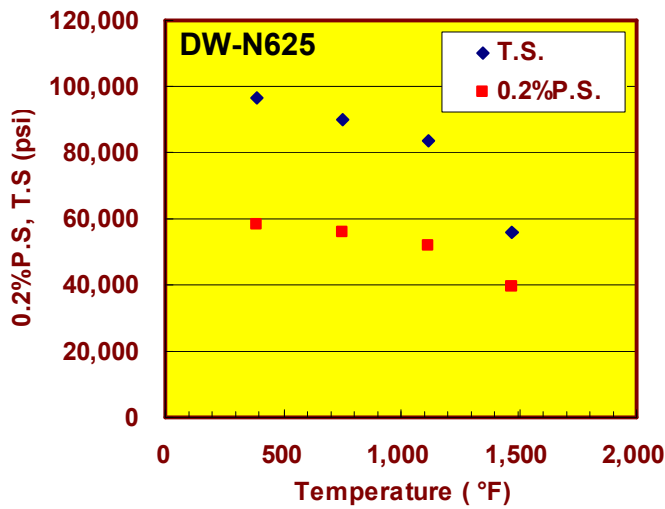
Wire	C	Mn	Fe	P	S	Si	Cu	Ni
DW-N625	0.030	0.41	4.1	0.008	0.002	0.36	0.01	60.8
DW-NC276	0.018	0.74	6.2	0.009	0.004	0.16	0.06	57.5

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%CO₂)

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")

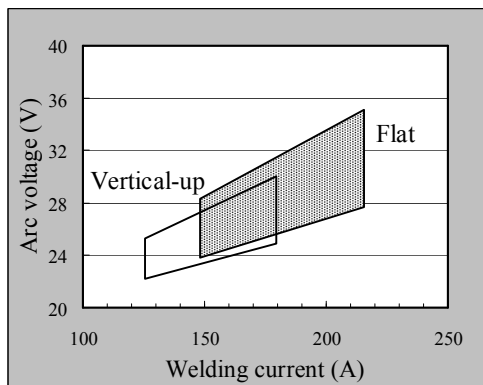


Tensile properties at high temperatures

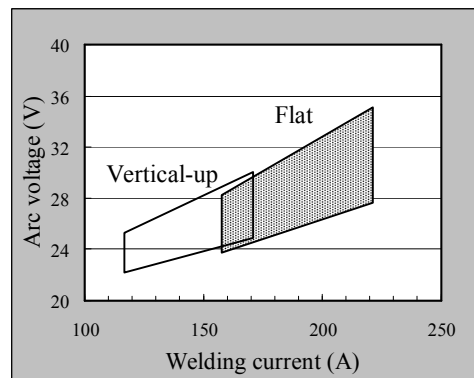


Base material:
Alloy 825
Wall thickness: 15/32"
Welding parameter:
160A/26-27V
Shielding gas:
75%Ar-25%CO₂

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



DW-N625



DW-NC276

Recommended welding parameters (75%Ar-25%CO₂)