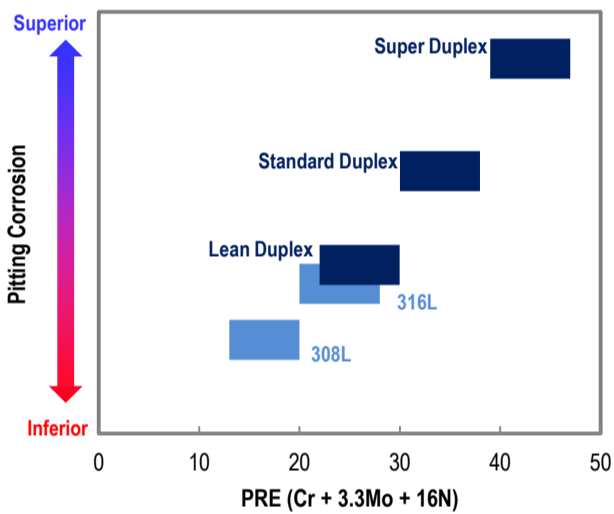


Welding Consumables for Duplex Stainless Steel

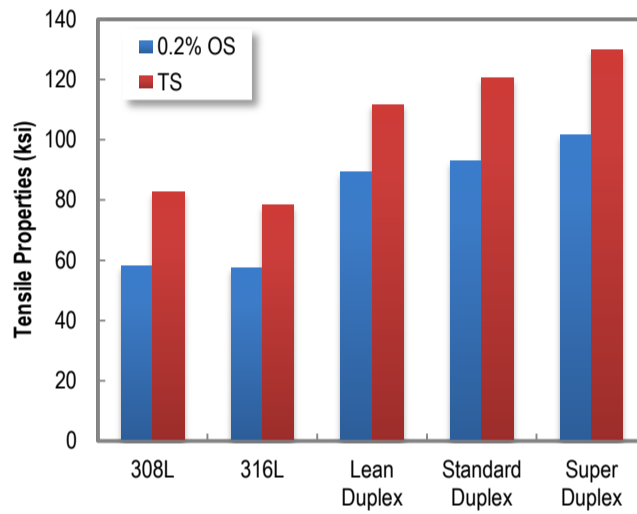
Line-up of Welding Consumables for Duplex Stainless Steel

Type of steel	SMAW	FCAW	TGAW	SAW
Lean duplex	-	PREMARC DW-2307 (A5.22 E2307T1-1/4)	-	-
Standard duplex	PREMARC NC-2209 (A5.4 E2209-16)	PREMARC DW-2209 (A5.22 E2209T1-1/4)	PREMARC TG-S2209 (A5.9 ER2209) PREMARC TG-K2209 (-)	PREMARC US-2209 / PF-S1D (A5.9 ER2209)
Super duplex	PREMARC NC-2594 (A5.4 E2594-16)	PREMARC DW-2594 (A5.22 E2594T1-1/4)	PREMARC TG-S2594 (A5.9 ER2594)	-

Excellent Corrosion Resistance and Strength



PRE and Pitting Corrosion Property



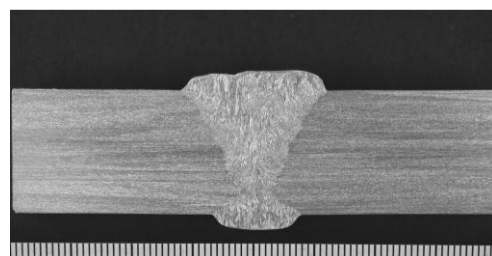
Tensile Property



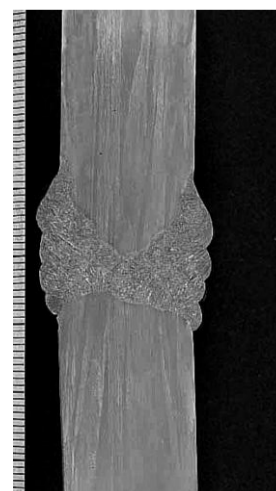
Application:
Chemical Plant, Offshore, Chemical Tanker

Flux Cored Wires for Duplex Stainless Steel

Product name	Chemical composition (%)							PRE	FN	0.2%OS (ksi)	TS (ksi)	EI (%)	IV (ft-lbf)	
	C	Si	Mn	Ni	Cr	Mo	N						32°F	-40 °F
PREMARC DW-2307	0.026	0.45	1.26	7.9	24.6	0.03	0.15	27.1	41	82.8	108.8	29	43	33
PREMARC DW-2209	0.023	0.59	0.91	9.7	23.2	3.2	0.14	36.0	43	91.4	118.2	28	54	46
PREMARC DW-2594	0.026	0.50	1.18	9.6	25.7	3.8	0.24	42.0	49	103.3	131.3	27	41	29



Wire: **PREMARC DW-2594**
Base Metal: S32760, 3/4"
Vertical-up (3G)



Wire: **PREMARC DW-2209**
Base Metal: S31803, 3/4"
Horizontal (2G)

