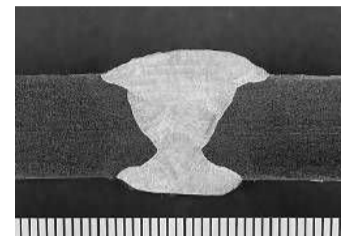


# Welding Consumables for Low Temperature Service & High Corrosion Resistant Steel

## Flux Cored Wires for Nickel Based Alloy Steel

Application for Nickel alloy, High corrosion-resistant super stainless, Orbital welding of inner pipe and Corrosion-resistant cladding on carbon steel.

Product Name	Chemical composition of weld metal (%)								
	C	Si	Mn	Ni	Cr	Mo	Fe	Nb	W
<b>PREMIARC DW-N625</b> (A5.34 ENiCrMo3T1-4)	0.03	0.36	0.41	62.8	22.2	8.6	2.1	3.59	-
<b>PREMIARC DW-NC276</b> (A5.34 ENiCrMo4T1-4)	0.02	0.16	0.74	57.5	15.5	15.9	6.2	-	3.6
<b>PREMIARC DW-N82</b> (A5.34 ENiCr3T0-4)	0.04	0.26	3.22	70.2	20.9	-	2.2	2.6	-



**PREMIARC DW-N625**  
Super stainless steel (1/2")  
160A – 27V  
Vertical upward (3G)

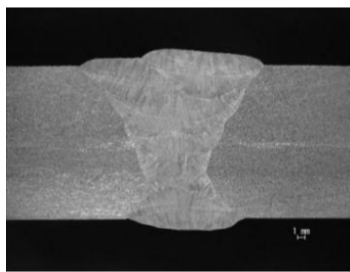
New Product!

PREMIARC DW-A904L

## Flux Cored Wire for 904L Type Stainless Steel

EN ISO 17633 –A- 20 25 5 Cu N L P M21 2

Chemical composition (%)								0.2%OS (ksi)	TS (ksi)	EI (%)	IV@-320°F (ft-lbf)	CPT*
C	Si	Mn	Cu	Ni	Cr	Mo	N					
0.03	0.66	1.56	1.34	25.3	20.9	4.8	0.13	61.4	96.3	36	45	104 °F (40 °C)

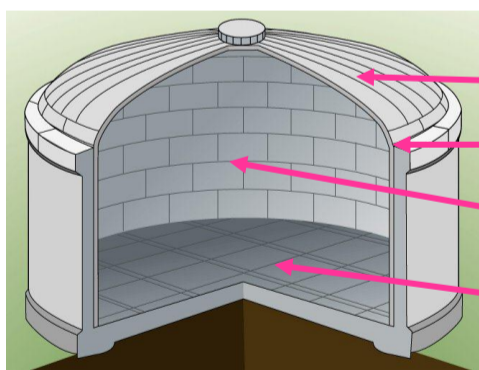


\* CPT: Critical Pitting Temperature, ASTM G48 Practice E, Test solution: 6% FeCl<sub>3</sub> + 1% HCl, Exposure time: 24 hrs.

**PREMIARC DW-A904L**  
904L stainless steel (3/4")  
160A – 25V  
Vertical upward (3G)



## Welding Consumables for LNG Tank



Part	Welding position	Process
<b>Roof</b>	4G, 2G, 2F	SMAW, FCAW, SAW
<b>Knuckle</b>	1G, 3G	SMAW, GTAW
<b>Side Shell</b>	3G	SMAW, FCAW, GTAW
	2G	SAW
<b>Floor</b>	1G, 2F	SMAW, SAW, GTAW
<b>Stiffener</b>	All position	SMAW



Product Name	Welding Process	Chemical composition (%)									0.2%OS (ksi)	TS (ksi)	EI (%)	IV@-320°F (ft-lbf)
		C	Si	Mn	Ni	Cr	Mo	Fe	Nb	W				
<b>PREMIARC NI-C70S</b> (A5.11 ENiCrFe-9)	<b>SMAW</b>	0.09	0.23	2.20	65.0	16.5	4.9	8.8	1.4	0.6	65.2	103.0	41	49
<b>PREMIARC NI-C1S</b> (A5.11 ENiMo-8)		0.03	0.49	0.28	68.6	1.9	18.6	6.8	-	2.9	63.8	105.9	48	61
<b>PREMIARC TG-S709S</b> (A5.14 ERNiMo-8)	<b>GTAW</b>	0.02	0.02	0.02	69.8	2.0	19.1	5.6	-	3.0	66.7	105.9	47	118
<b>PREMIARC US-709S / PF-N4</b> (A5.14 ERNiMo-8: Wire)	<b>SAW</b>	0.03	0.74	0.58	64.0	1.7	17.2	15	-	2.7	63.1	103.8	48	65
<b>PREMIARC DW-N709SP</b> (A5.34 ENiMo13T1-4)	<b>FCAW</b>	0.02	0.2	2.70	62.1	7.0	17.6	-	-	2.4	66.6	104.1	46	66
<b>PREMIARC DW-N625</b> (A5.34 ENiCrMo3T1-4)		0.03	0.36	0.29	62.8	22.2	8.6	2.1	3.6	-	71.1	111.1	43	44