

DW-N625

AWS A5.34 ENiCrMo3T1-4

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)

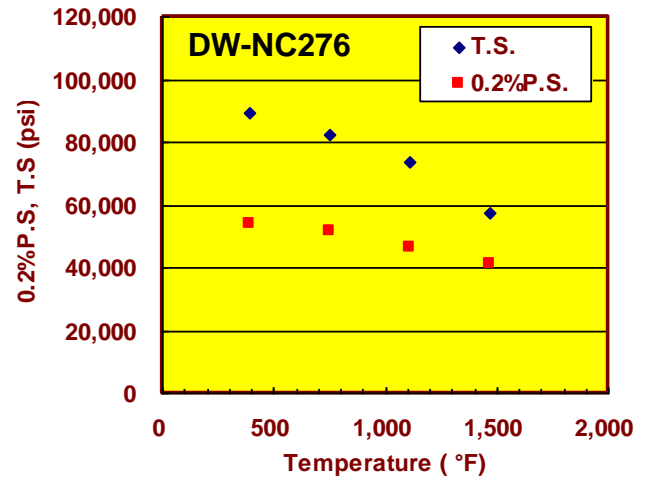
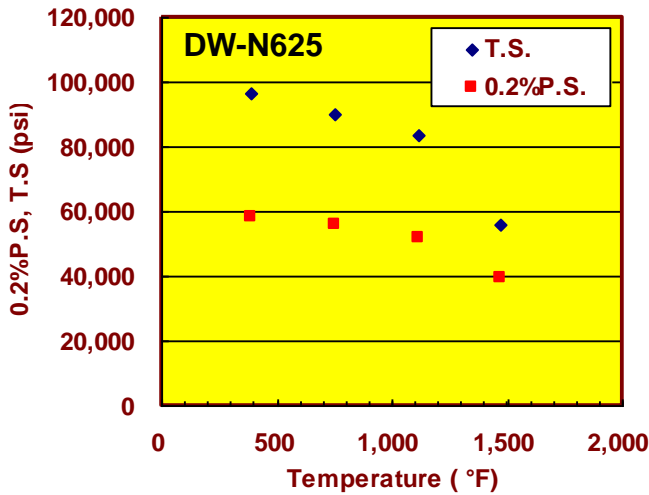
| Wire | C | Mn | Fe | P | S | Si | Cu | Ni |
|----------|-------|------|-----|-------|-------|------|------|------|
| DW-N625 | 0.030 | 0.41 | 4.1 | 0.008 | 0.002 | 0.36 | 0.01 | 60.8 |
| DW-NC276 | 0.018 | 0.74 | 6.2 | 0.009 | 0.004 | 0.16 | 0.06 | 57.5 |

| 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")

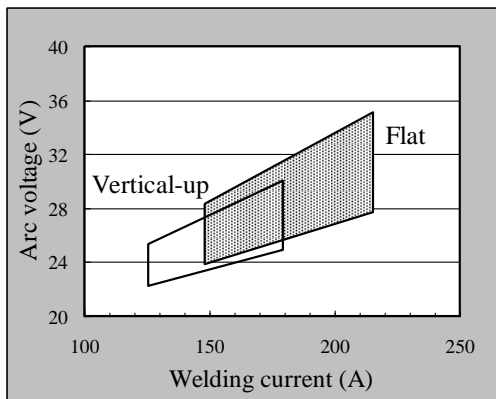


Tensile properties at high temperatures

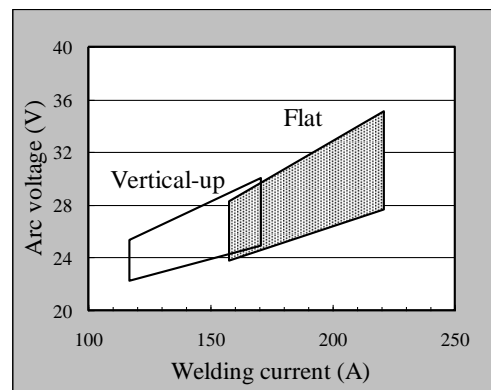


Base material:
 Alloy 825
 Wall thickness: 15/32"
 Welding parameter:
 160A/26-27V
 Shielding gas:
 75%Ar-25%CO₂

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



DW-N625



DW-NC276

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



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

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