DW-312 PREMIARC™

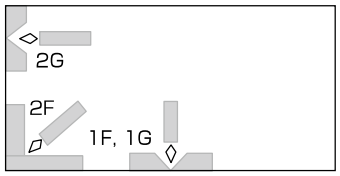
Flux cored wire

Features:
- Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals

Classification: AWS A5.22 E312T0-1

Shielding gas: CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.11	0.15
Si	0.5	1.0
Mn	1.6	0.5~2.5
P	0.02	0.04
S	0.01	0.03
Ni	10.2	8.0~10.5
Cr	28.4	28.0~32.0
Mo	0.02	0.75
Cu	0.02	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
1.2	130~270	150~220

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	600	-
TS (MPa)	720	655min.
El on 4d (%)	23	22min.

Approvals

CWB	E312T0-1