DW-2307 PREMIARC™

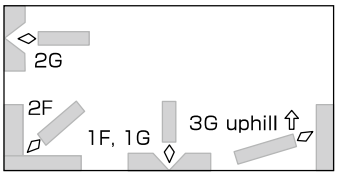
Flux cored wire

Features: ▪ Suitable for lean duplex stainless steel of S32101, S32304, S82122

Classification: AWS A5.22 E2307T1-1/4

Shielding gas: CO_2 or Ar-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 (Ar-CO_2)	Guaranty [a]
C	0.02	0.04
Si	0.6	1.0
Mn	1.4	2.0
P	0.02	0.03
S	<0.01	0.02
Ni	8.3	6.5~10.0
Cr	24.6	22.5~25.5
Mo	0.05	0.8
Cu	0.03	0.50
N	0.13	0.10~0.20
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill
1.2	130~250	150~220	130~180

All-weld mechanical properties

	Typical (Ar-CO_2)	Guaranty
0.2%YS (MPa)	590	-
TS (MPa)	754	690min.
El on 4d (%)	29	20min.
IV 0℃ (J)	52	-