NC-32 PREMIARC™

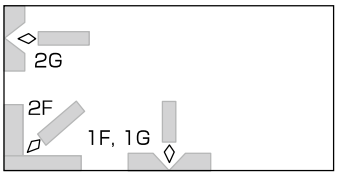
Stick electrode

Features:
- Suitable for dissimilar joint between carbon steel and stainless steel rich in carbon or nickel.

Classification: AWS A5.4 E312-16

Redrying Conditions: 150~250℃x0.5-1h
Identification color: 1st Green, 2nd Red
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
3.2	300	2	20	27	300W, 110H, 330L
4.0	350	5	20	49	175W, 120H, 380L
5.0	350	5	20	76	175W, 120H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.13	0.15
Si	0.62	1.00
Mn	1.2	0.5~2.5
P	0.01	0.04
S	<0.01	0.03
Ni	9.6	8.0~10.5
Cr	28.2	28.0~32.0
Mo	0.01	0.75
Cu	0.05	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G
3.2	70~115
4.0	95~145
5.0	135~180

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	624	-
TS (MPa)	785	655min.
El on 4d (%)	20	22min.