NC-37 PREMIARC™

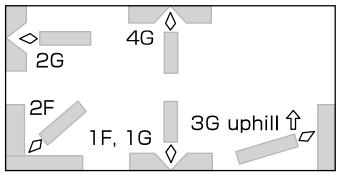
Stick electrode

Features: ▪ Suitable for 18%Cr-8%Ni-Nb steel

Classification: AWS A5.4 E347-16

Redrying Conditions: 150~200℃x0.5~1h
Identification color: 1st Blue, 2nd Blue
Polarity: AC, DCEP

Welding Positions:



Packaging data

ϕ mm	Length mm	kg/pack	kg/carton	g/piece	carton mm
2.6	250	2	20	15	300W, 100H, 280L
3.2	300	2	20	28	300W, 95H, 330L
4.0	350	5	20	50	175W, 120H, 380L
5.0	350	5	20	77	175W, 120H, 380L

Composition (all-weld metal mass%)

	Typical (AC)	Guaranty [a]
C	0.06	0.08
Si	0.55	1.00
Mn	1.5	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	10.1	9.0~11.0
Cr	19.6	18.0~21.0
Mo	0.04	0.75
Cu	0.04	0.75
Nb+Ta	0.67	8xC%~1.00

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
2.6	50~85	45~80
3.2	70~115	65~110
4.0	95~145	85~135
5.0	135~180	-

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	470	-
TS (MPa)	670	518min.
El on 4d (%)	34	30min.