N04051 PREMIARC™

Filler rod and wire

Features: ▪ Suitable for modified 316 stainless steel of urea plant

Classification: AWS -

Shielding gas: Ar

Identification color: -

Polarity: DCEN

Packaging data

	Spool	Tube		
ϕ mm	kg	kg	Length mm	g/piece
1.0	10	5	1,000	6
1.2	10	5	1,000	9
1.6	10	5	1,000	16
2.0	-	5	1,000	25
2.4	-	5	1,000	36
Volume mm	240W, 110H, 240L	40W, 35H, 1015L		

Composition (rod and wire mass%)

	Typical	Guaranty [a]
C	0.005	0.045
Si	0.16	1.00
Mn	6.10	4.00~7.00
P	0.011	0.030
S	0.004	0.020
Ni	16.29	14.00~18.00
Cr	18.24	17.00~19.50
Mo	2.56	2.20~3.00
N	0.01	0.20

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	
1.0	50~80
1.2	50~100
1.6	100~200
2.0	100~200
2.4	150~250

All-weld mechanical properties

	Typical
0.2%YS (MPa)	360
TS (MPa)	490
El on 4d (%)	41
IV -257℃ (J)	99