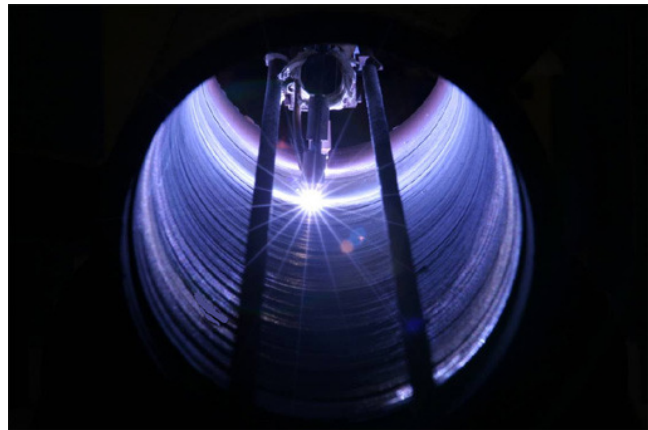


Cromacore DW-309LNb

A stainless steel FCW for overlay welding of 2,25Cr-1Mo steels.

In overlay welding the target is to reach a specific overlay chemistry in as few layers as possible. The most efficient method is to use an overmatching consumable in order to handle the dilution from the base material and achieve the desired deposit composition in a single layer. In other cases two layers are deposited, one regular 309L stainless steel grade and finally a wire with the required analysis.



In this case a Nb-stabilised weld deposit of the 347 type is required as the welded component is to be used at temperatures exceeding 400°C. Typical applications include heat exchangers and hydrocrackers. For this reason one can either weld two layers, one layer with 309L and a final layer of 347 or one can weld a single layer with Cromacore DW-309LNb. Both a cost saving and time saving choice!

Classification

AWS A5.22 E309LCbT1-1/4

Product code

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