

# PRODUCT DATA SHEET

## Inox DW



Inox DW is an austenitic-ferritic electrode with approximately 50% ferrite content and is non-scaling to 1100°C. The weld metal of Inox DW is highly crack resistant and is therefore suitable for difficult to weld steels and joining dissimilar materials, e.g. high alloy and unalloyed steels. It is also suitable as a stress compensating buffer layer on parent metals susceptible to cracking. Good all positional weldability. Unalloyed steels with C > 0,25% should be preheated to 150-300°C depending on the carbon content and plate thickness. Note: Do not use for dissimilar joints in creep resisting applications.

### Open Circuit Voltage

70 min

### Re-drying

Only dry electrodes should be used. Re-drying should be carried out at 300°C for 2 hours.

Classifications		
AWS	A5.4	E312-16
ISO	3581-A	E29 9 R12
ISO	3581-B	ES 312-16

Typical Chemical Analysis			
% Carbon	0,12 max	% Chromium	29,0
% Manganese	1,0	% Nickel	9,0
% Silicon	0,9		

Typical Mechanical Properties (All weld metal in the as welded condition)	
0,2% Proof Stress	>500 MPa
Tensile Strength	740 - 840 MPa
% Elongation on 5d	>22
Microstructure	Austenitic with approximately 50% delta ferrite

Packing Data (DC+ AC 70 OCV min)				
Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
2,5	300	55 - 85	5,0	WI13082
3,25	350	80 - 120	5,0	WI13083
4,0	350	110 - 150	5,0	WI13084
5,0	350	160 - 200	5,0	WI13085

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