DW-308H PREMIARC™

Flux cored wire

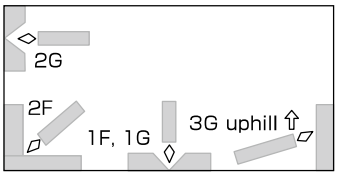
Features:
- Suitable for 18%Cr-8%Ni steel for high temperature service
- Bi-free type

Classification: AWS A5.22 E308HT1-1/4

Shielding gas: CO_2 or Ar-CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.05	0.04~0.08
Si	0.5	1.0
Mn	1.2	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	9.6	9.0~11.0
Cr	19.0	18.0~21.0
Mo	0.02	0.75
Cu	0.03	0.75
Bi	<0.0005	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill
1.2	130~270	150~220	130~180

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	370	-
TS (MPa)	560	552min.
El on 4d (%)	48	30min.
IV 0℃ (J)	71	-

Approvals

CWB	E308HT1-1, E308HT1-4