DW-308L PREMIARC™

Flux cored wire

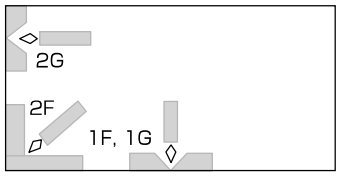
Features: ▪ Applied for 304L type steel

Classification: AWS A5.22 E308LT0-1/4

Shielding gas: CO_2 or Ar-CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
0.9	5kg	12.5kg
1.2	-	12.5kg
1.6	-	12.5kg
Volume mm	235W, 110H, 230L	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.6	1.0
Mn	1.5	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	10.0	9.0~11.0
Cr	19.5	18.0~21.0
Mo	0.02	0.75
Cu	0.03	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
0.9	80~150	90~130
1.2	130~270	150~220
1.6	190~320	220~270

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	370	-
TS (MPa)	550	518min.
El on 4d (%)	42	30min.
IV 0℃ (J)	41	-

Approvals

ABS	MG
LR	304L S (CHEM & CRYO)
DNV	VL308L, MG (CO_2) VL308L (Ar-CO_2)
NK	KW308LG (C)
CWB	E308LT0-1, E308LT0-4

Note: CO_2, except in CWB/DNV