# DW-308LP PREMIARC™

**Flux cored wire**

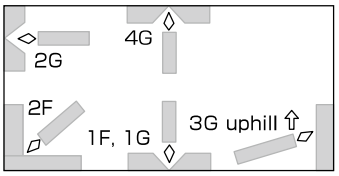
**Features:** ▪ Applicable for 304 and 304L type steel

**Classification:** AWS A5.22 E308LT1-1/4

**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** | 0.02 | 0.04 |
| **Si** | 0.8 | 1.0 |
| **Mn** | 1.1 | 0.5~2.5 |
| **P** | 0.02 | 0.04 |
| **S** | <0.01 | 0.03 |
| **Ni** | 9.9 | 9.0~11.0 |
| **Cr** | 20.3 | 18.0~21.0 |
| **Mo** | 0.02 | 0.75 |
| **Cu** | 0.03 | 0.75 |
| **Bi** | >0.002 | - |

Note: [a] Single values are maximum.

## All-weld mechanical properties

| | Typical ($CO_2$) | Guaranty |
|---|---|---|
| **0.2%YS (MPa)** | 380 | - |
| **TS (MPa)** | 550 | 518min. |
| **El on 4d (%)** | 45 | 30min. |
| **IV 0℃ (J)** | 57 | - |

## Approvals

| | |
|---|---|
| **ABS** | MG (AWS A5.22 E308LT1-1) |
| **LR** | 304L S (CHEM & CRYO) |
| **DNV** | VL308L, MG |
| **BV** | 308L BT |
| **NK** | KW308LG (C) |
| **KR** | RW308LG (C) |
| **CWB** | E308LT1-1, E308LT1-4 |

Note: $CO_2$, except in CWB

## Welding parameters (A)

| ϕ mm | 1F, 1G, 2F | 2G | 3G uphill | 4G |
|---|---|---|---|---|
| 1.2 | 130~270 | 150~220 | 130~220 | 150~200 |