DW-308LT PREMIARC™

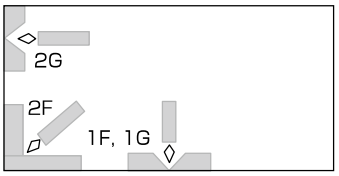
Flux cored wire

Features: ▪ Suitable for 18%Cr-8%Ni steel for low temperature service

Classification: AWS A5.22 E308LT0-1/4

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	0.03	0.04
Si	0.3	1.0
Mn	2.2	0.5~2.5
P	0.02	0.04
S	0.01	0.03
Ni	10.3	9.0~11.0
Cr	18.6	18.0~21.0
Mo	0.01	0.75
Cu	0.05	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

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

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	380	-
TS (MPa)	530	518min.
El on 4d (%)	51	30min.
IV -196℃ (J)	39	27min.