DW-308L-XR PREMIARC™

Flux cored wire

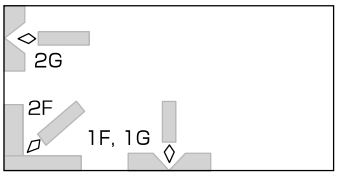
Features:
- Applied for 304L type stainless steel
- Low Cr (Ⅵ) stainless steel flux cored wire

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 (wire mass%)

	Typical (Ar-CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.7	1.0
Mn	1.3	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	9.5	9.0~11.0
Cr	19.4	18.0~21.0
Mo	0.01	0.75
Cu	0.02	0.75

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 (Ar-CO_2)	Guaranty
0.2%YS (MPa)	396	-
TS (MPa)	583	518min.
El on 4d (%)	42	30min.

Approvals

CWB	E308LT0-1, E308LT0-4