DW-309 PREMIARC™

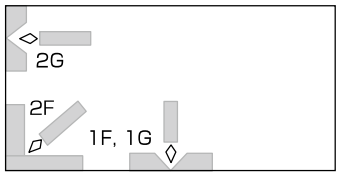
Flux cored wire

Features: ▪ Suitable for dissimilar-metal joint and underlaying on ferritic steels

Classification: AWS A5.22 E309T0-1/4

Shielding gas: CO_2 or Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	Drum
1.2	12.5kg	200kg
1.6	12.5kg	-
Volume mm	295W, 110H, 295L	680ϕ, 770H

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.03	0.10
Si	0.7	1.0
Mn	1.2	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.3	12.0~14.0
Cr	24.0	22.0~25.0
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
1.2	130~270	150~220
1.6	190~320	220~270

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	450	-
TS (MPa)	590	552min.
El on 4d (%)	32	30min.
IV 0℃ (J)	33	-

Approvals

LR	SS/CMn S (CHEM)

Note: CO_2