DW-309L PREMIARC™

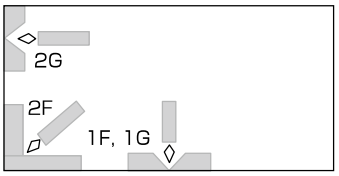
Flux cored wire

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

Classification: AWS A5.22 E309LT0-1/4

Shielding gas: CO_2 or Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		Drum	
0.9	5kg	12.5kg	-	-
1.2	-	12.5kg	150kg	-
1.6	-	12.5kg	-	200kg
Volume mm	235W, 110H, 230L	295W, 110H, 295L	530ϕ, 820H	680ϕ, 770H

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.6	1.0
Mn	1.2	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.4	12.0~14.0
Cr	23.8	22.0~25.0
Mo	0.03	0.75
Cu	0.02	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)	450	-
TS (MPa)	580	518min.
El on 4d (%)	33	30min.

Approvals

ABS	MG
LR	SS/CMn S (CHEM) (CO_2) SS/CMn S (CHEM), Dup/CMnS (CHEM) (Ar-CO_2)
DNV	VL309L
BV	UP
NK	KW309LG (C)
CWB	E309LT0-1, E309LT0-4

Note: CO_2, except in LR/CWB