DW-309LH PREMIARC™

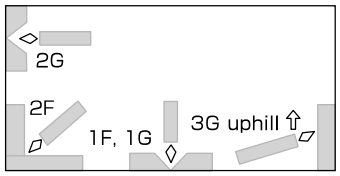
Flux cored wire

Features:
- Suitable for dissimilar metal joint of solution heat treatment and underlaying on ferritic steels for overlaying stainless steel weld metals
- Bi-free type

Classification: AWS A5.22 E309LT1-1/4

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	0.4	1.0
Mn	1.2	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.6	12.0~14.0
Cr	23.1	22.0~25.0
Mo	0.02	0.75
Cu	0.02	0.75
Bi	<0.0005	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill
1.2	130~270	150~220	130~180

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	380	-
TS (MPa)	590	518min.
El on 4d (%)	36	30min.