DW-309LP PREMIARC™

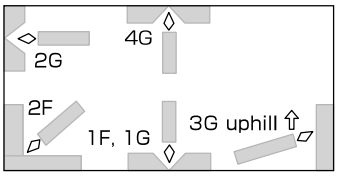
Flux cored wire

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

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	0.02	0.04
Si	0.8	1.0
Mn	0.8	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.4	12.0~14.0
Cr	23.2	22.0~25.0
Mo	0.02	0.75
Cu	0.02	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	430	-
TS (MPa)	570	518min.
El on 4d (%)	38	30min.

Approvals

	CO_2	Ar-CO_2
ABS	MG (AWS A5.22 E309LT1-1)	MG (AWS A5.22 E309LT1-4)
LR	SS/CMn S (CHEM & CRYO), Dup/CMnS (CHEM)	SS/CMn S (CHEM)
DNV	VL309L	VL309L
BV	309L, UP	-
NK	KW309LG (C)	-
KR	RW309LG (C)	-
CCS	309L, UP	-
CWB	E309LT1-1	E309LT1-4

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill	4G
1.2	130~270	150~220	130~220	150~200