DW-309LP-XR PREMIARC™

Flux cored wire

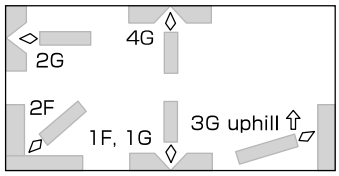
Features:
- Suitable for dissimilar-metal joint and underlaying on ferritic steels
- Low Cr (Ⅵ) stainless steel flux cored wire

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 (wire mass%)

	Typical (Ar-CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.7	1.0
Mn	1.0	0.5~2.5
P	0.01	0.04
S	<0.01	0.03
Ni	12.3	12.0~14.0
Cr	24.2	22.0~25.0
Mo	0.02	0.75
Cu	0.01	0.75

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical (Ar-CO_2)	Guaranty
0.2%YS (MPa)	430	-
TS (MPa)	562	518min.
El on 4d (%)	37	30min.

Approvals

ABS*	MG (AWS A5.22 E309LT1-4)
CWB	E309LT1-1, E309LT1-4

Note: *Ar-25%CO_2

Welding parameters (A)

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