DW-309L-XR PREMIARC™

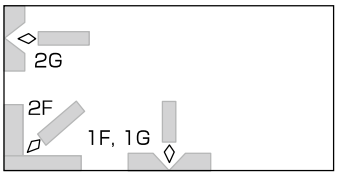
Flux cored wire

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

Classification: AWS A5.22 E309LT0-1/4

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	0.8	1.0
Mn	1.1	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.4	12.0~14.0
Cr	24.1	22.0~25.0
Mo	0.03	0.75
Cu	0.03	0.75

Note: [a] Single values are maximum.

Welding parameters (A)

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

All-weld mechanical properties

	Typical (Ar-CO_2)	Guaranty
0.2%YS (MPa)	454	-
TS (MPa)	608	518min.
El on 4d (%)	32	30min.

Approvals

CWB	E309LT0-1, E309LT0-4