DW-309MoL PREMIARC™

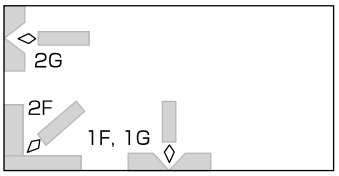
Flux cored wire

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

Classification: AWS A5.22 E309LMoT0-1/4

Shielding gas: CO_2 or Ar-CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
1.6	12.5kg
Volume mm	295W, 110H, 295L

Composition (all-weld metal mass%)

	Typical (CO_2)	Guaranty [a]
C	0.03	0.04
Si	0.7	1.0
Mn	1.4	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.3	12.0~16.0
Cr	23.2	21.0~25.0
Mo	2.4	2.0~3.0
Cu	0.07	0.75
Bi	>0.002	-

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G
1.2	130~270	150~220
1.6	190~320	220~270

All-weld mechanical properties

	Typical (CO_2)	Guaranty
0.2%YS (MPa)	540	-
TS (MPa)	720	518min.
El on 4d (%)	30	25min.

Approvals

ABS	MG
LR	SS/CMn S (CHEM)
DNV	VL309MoL (CO_2/Ar-CO_2)
BV	UP
NK	KW309MoLG (C) KW309MoLG (C)-YP315M-TS550M

Note: CO_2, except in DNV