

FCAW

# DW-309MoLP

**PREMIARC™**

## Flux cored wire

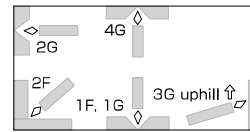
**Features:** ■ Suitable for dissimilar-metal joint and underlaying on ferritic steels

**Classification:** AWS A5.22 E309LMoT1-1/4

**Shielding gas:** CO<sub>2</sub> or Ar-CO<sub>2</sub>

**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 <sub>2</sub> )	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.4	1.0
<b>Mn</b>	0.6	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	12.4	12.0~16.0
<b>Cr</b>	22.3	21.0~25.0
<b>Mo</b>	2.3	2.0~3.0
<b>Cu</b>	0.04	0.75
<b>Bi</b>	>0.002	-

Note: <sup>a</sup> Single values are maximum.

## All-weld mechanical properties

	Typical (CO <sub>2</sub> )	Guaranty
<b>0.2%YS (MPa)</b>	540	-
<b>TS (MPa)</b>	699	518min.
<b>EI on 4d (%)</b>	30	25min.

## Approvals

<b>NK</b>	KW309MoLG (C), KW309MoLG (C)- YP315M-TS550M
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Note: CO<sub>2</sub>

## Welding parameters (A)

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