

FCAW

# DW-308H

**PREMIARC™**

## Flux cored wire

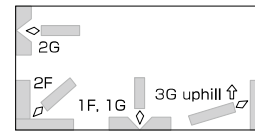
- Features:**
- Suitable for 18%Cr-8%Ni steel for high temperature service
  - Bi-free type

**Classification:** AWS A5.22 E308HT1-1/4

**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
<b>Volume mm</b>	295W, 110H, 295L

## Composition (all-weld metal mass%)

	Typical (CO <sub>2</sub> )	Guaranty <sup>a</sup>
<b>C</b>	0.05	0.04~0.08
<b>Si</b>	0.5	1.0
<b>Mn</b>	1.2	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	9.6	9.0~11.0
<b>Cr</b>	19.0	18.0~21.0
<b>Mo</b>	0.02	0.75
<b>Cu</b>	0.03	0.75
<b>Bi</b>	<0.0005	-

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

## Welding parameters (A)

φ mm	1F, 1G, 2F	2G	3G uphill
1.2	130~270	150~220	130~180

## All-weld mechanical properties

	Typical (CO <sub>2</sub> )	Guaranty
<b>0.2%YS (MPa)</b>	370	-
<b>TS (MPa)</b>	560	552min.
<b>EI on 4d (%)</b>	48	30min.
<b>IV 0°C (J)</b>	71	-

## Approvals

CWB	E308HT1-1, E308HT1-4
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