

FCAW

## DW-308L-XR

PREMIARC™

### Flux cored wire

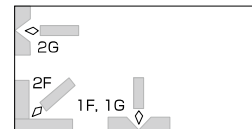
- Features:**
- Applied for 304L type stainless steel
  - Low Cr (VI) stainless steel flux cored wire

**Classification:** AWS A5.22 E308LT0-1/4

**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 (wire mass%)

	Typical (Ar-CO <sub>2</sub> )	Guaranty <sup>a</sup>
<b>C</b>	0.03	0.04
<b>Si</b>	0.7	1.0
<b>Mn</b>	1.3	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	9.5	9.0~11.0
<b>Cr</b>	19.4	18.0~21.0
<b>Mo</b>	0.01	0.75
<b>Cu</b>	0.02	0.75

Note: <sup>a</sup> 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 <sub>2</sub> )	Guaranty
<b>0.2%YS (MPa)</b>	396	-
<b>TS (MPa)</b>	583	518min.
<b>El on 4d (%)</b>	42	30min.

### Approvals

CWB	E308LT0-1, E308LT0-4
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