

FCAW

# DW-308LP

**PREMIARC™**

## Flux cored wire

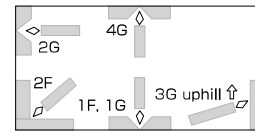
**Features:** ■ Applicable for 304 and 304L type steel

**Classification:** AWS A5.22 E308LT1-1/4

**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>	0.02	0.04
<b>Si</b>	0.8	1.0
<b>Mn</b>	1.1	0.5~2.5
<b>P</b>	0.02	0.04
<b>S</b>	<0.01	0.03
<b>Ni</b>	9.9	9.0~11.0
<b>Cr</b>	20.3	18.0~21.0
<b>Mo</b>	0.02	0.75
<b>Cu</b>	0.03	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>	380	-
<b>TS (MPa)</b>	550	518min.
<b>El on 4d (%)</b>	45	30min.
<b>IV 0°C (J)</b>	57	-

## Approvals

<b>ABS</b>	MG (AWS A5.22 E308LT1-1)
<b>LR</b>	304L S (CHEM & CRYO)
<b>DNV-GL</b>	VL308L, MG
<b>BV</b>	308L BT
<b>NK</b>	KW308LG (C)
<b>KR</b>	RW308LG (C)
<b>CWB</b>	E308LT1-1, E308LT1-4

Note: CO<sub>2</sub>, except in CWB

## Welding parameters (A)

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