Exocor
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DW-308L

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

All-Weld-Metal (100%CO_2)

1-1. Chemical Composition

[Unit: mass%]

	C	Mn	Si	P	S	Ni	Cr	N
DW-308L	0.02	1.29	0.44	0.017	0.010	9.88	19.16	0.014
E308LT0-X	<0.04	0.5~2.5	<1.0	<0.04	<0.03	9.0~11.0	18.0~21.0	-----

	WRC_{-1992} (FN)	Shaeffler Diagram (%)	Delong Diagram (FN)
DW-308L	9.2	7.8	10.2
E308LT0-X	-------	-------	-------

1-2. Tensile Test

	0.2% Proof stress (psi)	Tensile strength (psi)	Elongation (%)	Reduction of Area (%)
DW-308L	61,132	78,898	42	47
E308LT0-X	---	>75,000	>35	---

Note) Test was completed in the as welded condition and at room temperature

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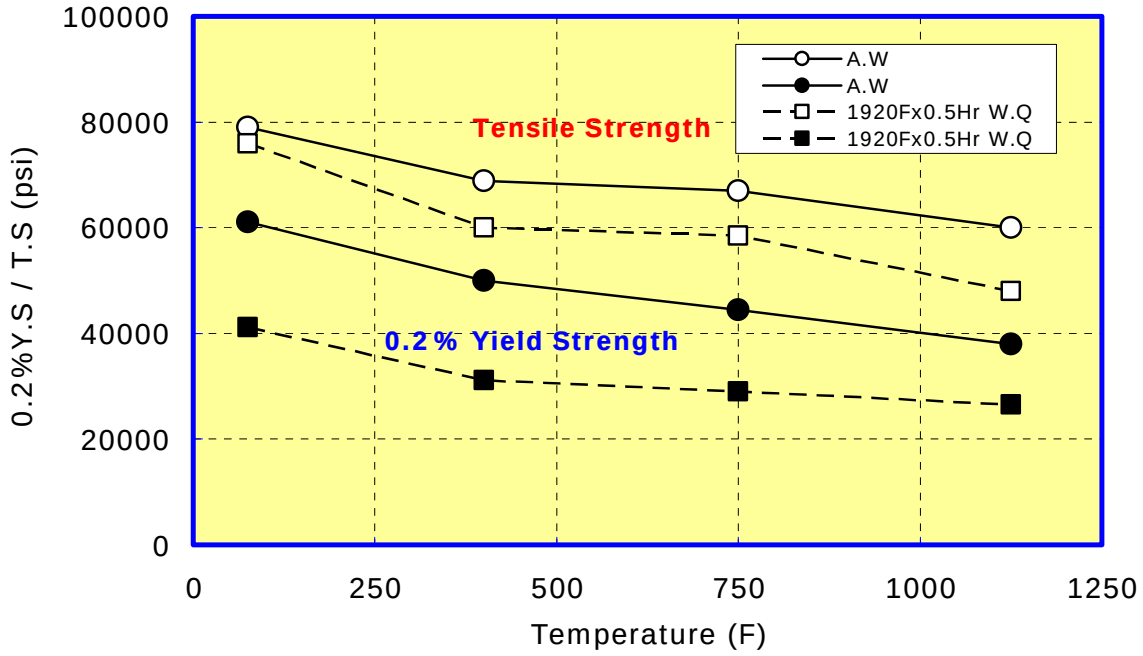

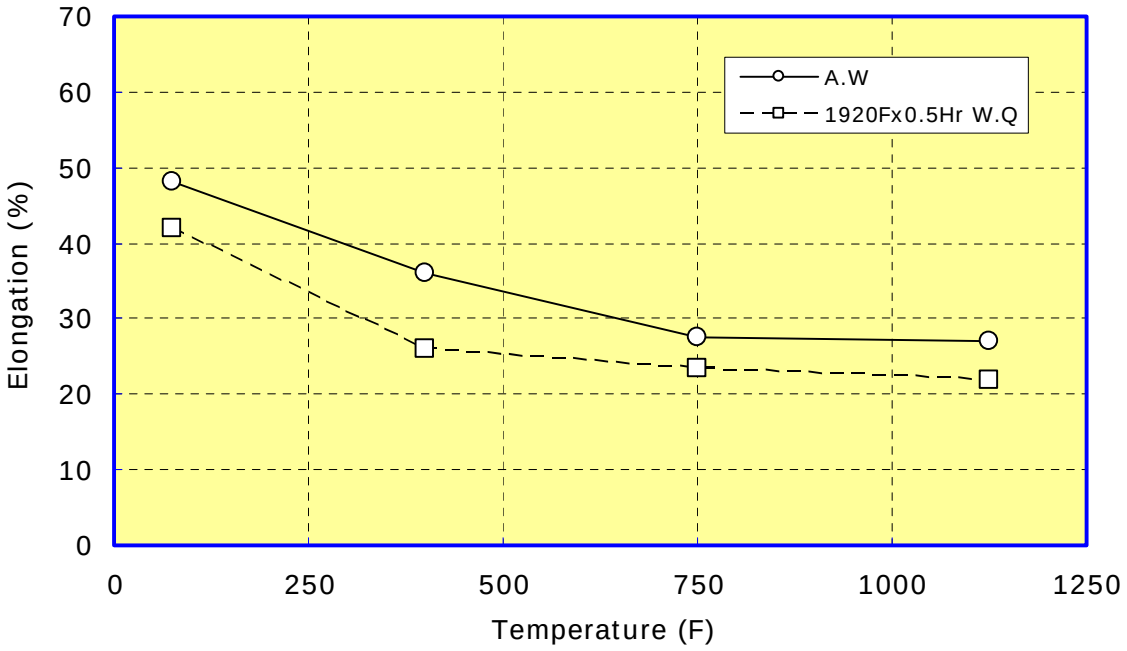

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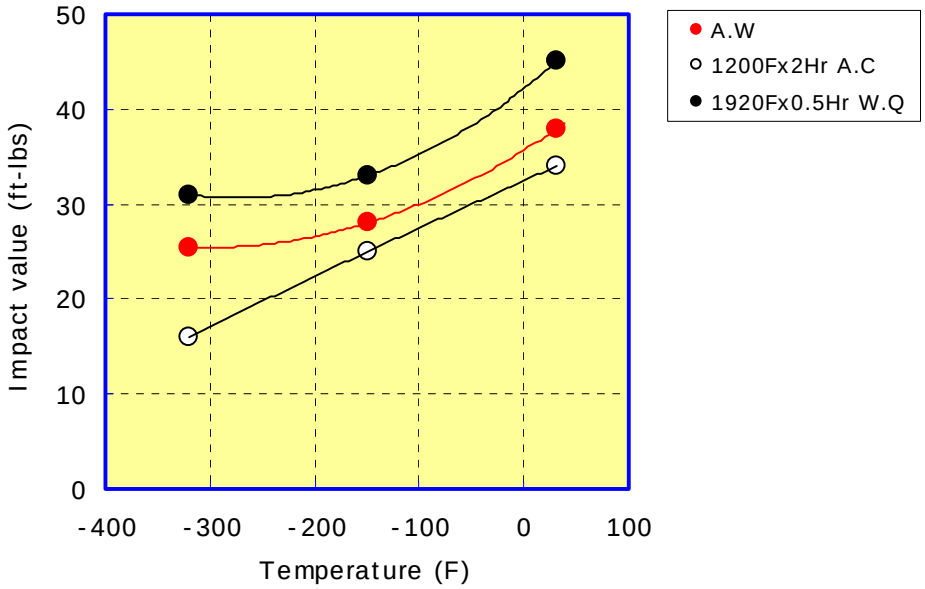
1-3. Impact Test



1-4. Corrosion Test

PWHT	Test results (IPM)			
	1st	2nd	3rd	Ave.
As Welded	0.00059	0.00065	0.00054	0.00059
1200°F - 2hr *	0.00081	0.00097	0.00101	0.00093
1920°F – 0.5hr **	0.00042	0.00045	0.00045	0.00044

* Air cooled

** Water quenched

Huey Test (65%Nitric Acid Test)

Welding Journal, Oct.1951 “Corrosion Data of Welding Low Carbon Stainless Steel”

Excellent < 0.0009 IPM
Good < 0.0009 – 0.0021 IPM
Fair < 0.0021 – 0.0042 IPM
Poor > 0.0042 IPM

Copper sulfuric acid test

PWHT : 1200°F x 2Hr A.C

Bend test results : No defect

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