

Flux Cored Arc Welding

DW-308LP

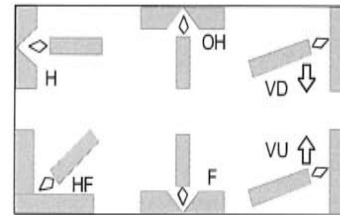
Rutile type flux cored wire for low carbon 18%Cr-8%Ni stainless steel

Classification: ASME / AWS A5.22 E308LT1-1/4
 EN 12073 T 19 9 L P C/M 1
 JIS Z3323 YF308LC

Features: •Applicable for 304 and 304L type steel
 •Suitable for butt and fillet welding in all positions including vertical downward
 •Lower carbon content than **DW-308**

Shielding gas: CO₂ or Ar-CO₂ mixture

Polarity: DC-EP

Welding positions:

Chemical composition of all-weld metal (%) as per AWS (Shielding gas: CO₂)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Example	0.027	0.55	1.51	0.022	0.010	9.89	19.45	0.02	0.03
Guaranty	≤0.040	≤1.00	0.50~ 2.50	≤0.040	≤0.030	9.00~ 11.00	18.00~ 21.00	≤0.50	≤0.50

Mechanical properties of all-weld metal as per AWS (Shielding gas: CO₂)

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	380	550	45	0°C: 57
Guaranty	-	≥520	≥35	-

Recommended welding parameters

Dia.	1.2mm	Dia.	1.2mm
F, HF	130~270A	OH	150~200A
H	150~220A	VD	150~200A
VU	130~220A		

VD position: multi-pass welding is not recommended.

Approvals

AB	LR	NV	BV	NK	Others
MG	304LMS (Chem. Cryo.)	308LMS	308LBT	KW308LG (C)	KR, CWB

Packages

Dia. (mm)	Type	Weight (kg)
1.2	Spool	12.5