

DW-309L

Classification: AWS A5.22 E309LT0-1
AWS A5.22 E309LT0-4

All-Weld-Metal (100%CO₂)

1-1. Chemical Composition

[Unit: mass%]

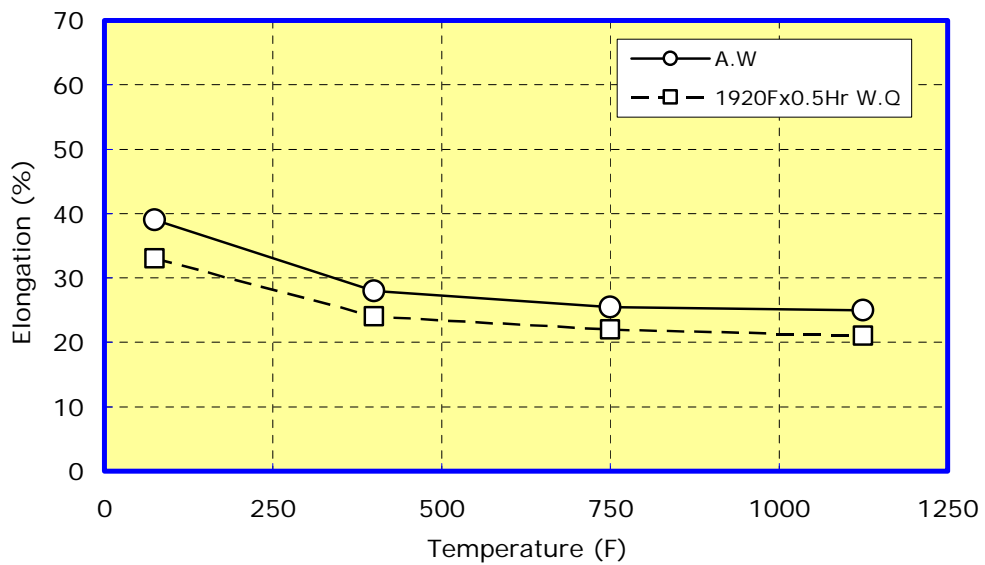
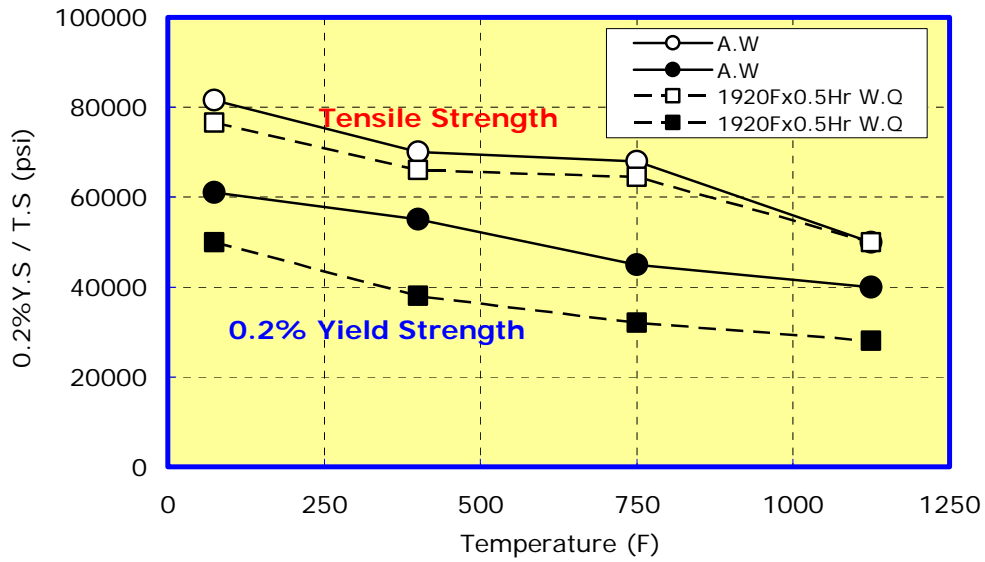
	C	Mn	Si	P	S	Ni	Cr	N
DW-309L	0.03	1.24	0.48	0.016	0.011	12.49	23.73	0.018
E309LT0-X	<0.04	0.5~2.5	<1.0	<0.04	<0.03	12.0~14.0	22.0~25.0	-----
	WRC ₋₁₉₉₂ (FN)		Shaeffler Diagram (%)		Delong Diagram (FN)			
DW-309L	19.2		12.6		>18			
E309LT0-X	-----		-----		-----			

1-2. Tensile Test

	0.2% Proof stress (psi)	Tensile strength (psi)	Elongation (%)	Reduction of Area (%)
DW-309L	60,907	81,218	34	42
E309LT0-X	---	>75,000	>30	---

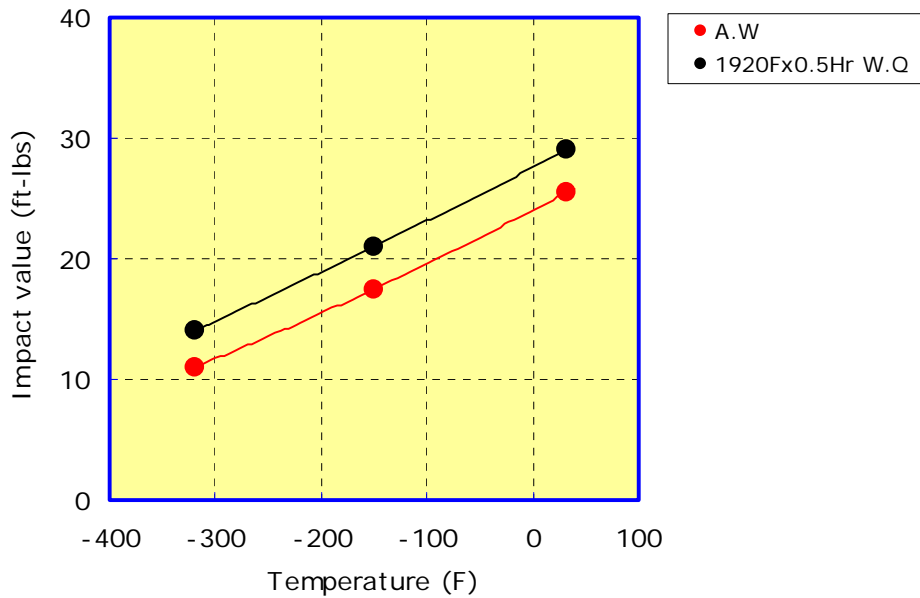
Note) Test was completed in the as welded condition and at room temperature

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1-3. Impact Test



1-4. Corrosion Test

Huey Test

PWHT	Test results (IPM)			
	1 st	2 nd	3 rd	Ave.
As Welded	0.00032	0.00029	0.00035	0.00032

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

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