

**Flux Cored Arc Welding**

# DW-309LP

**Rutile type flux cored wire for dissimilar metals**

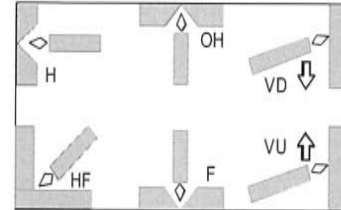
**Classification:** ASME / AWS A5.22 E309LT1-1/4  
 EN 12073 T 23 12 L P C/M 1  
 JIS Z3323 YF309LC

**Features :** • Suitable for dissimilar-metal joint and underlaying on ferritic steels for overlaying stainless steel weld metals

• Lower carbon content than **DW-309**

**Shielding gas:** CO<sub>2</sub> or Ar-CO<sub>2</sub> mixture

**Polarity:** DC-EP

**Welding positions:**

**Chemical composition of all-weld metal (%) as per AWS (Shielding gas: CO<sub>2</sub>)**

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
Example	0.027	0.56	1.21	0.023	0.009	12.45	23.55	0.04	0.06
Guaranty	≤0.040	≤1.00	0.50~ 2.50	≤0.040	≤0.030	12.00~ 14.00	22.00~ 25.00	≤0.50	≤0.50

**Mechanical properties of all-weld metal as per AWS (Shielding gas: CO<sub>2</sub>)**

	0.2%OS (MPa)	TS (MPa)	EI (%)
Example	430	570	38
Guaranty	-	≥520	≥30

**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**

LR	NV	BV	NK	Others
SS/CMn MS (Chem.,Cryo)	309L	309L	KW309LG(C)	CWB

**Packages**

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