



DW-308L represents a new generation of stainless flux cored wires by significantly reducing spatter and fumes over a wide range of welding parameters while featuring self-peeling slag removal and glossy bead appearance.

Basic characteristics of DW-308L

As shown in the AWS classification designations above, DW-308L is suited for flat and horizontal position welding with both CO₂ gas and 75-80%Ar + balanced CO₂ mixed gas shielding. DW-308L can be used in welding both 304L and 304 stainless steel.

What makes DW-308L a new generation wire?

Properly-controlled ferrite content (typically, 9% by Shaeffler Diagram) in DW-308L weld metal provides better resistibility to hot cracking. Additionally, low carbon content (typically, 0.027%) in DW-308L weld metal increases resistance to intergranular corrosion. The chemical composition of the weld metal provides superior mechanical properties and corrosion resistibility.

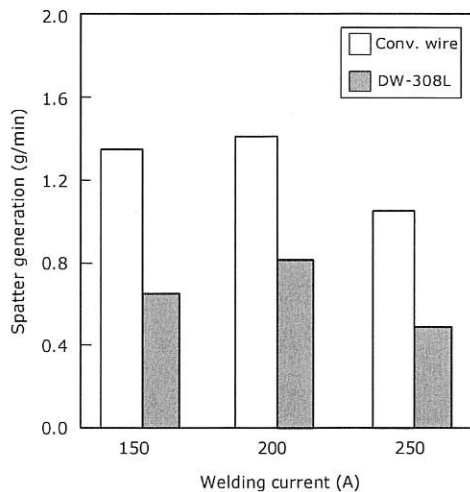


Figure 1: A comparison between DW-308L and conventional flux-cored wire in terms of spatter generation (Wire size: 1.2 mmØ; Shielding gas: 100%CO₂; Welding speed: 30cpm).

In addition to the sophisticated balance achieved in the chemical composition, DW-308L significantly lessens spatter and fumes. As shown in Figure 1, DW-308L reduces spatter by 40-50% over a range of welding parameters when compared to a conventional stainless flux cored wire. Materials savings can thus be realized in addition to savings in labor and material costs associated with postweld cleaning. As shown in Figure 2, DW-308L reduces fumes by 20-25% over a range of welding parameters when compared to a conventional stainless flux cored wire.

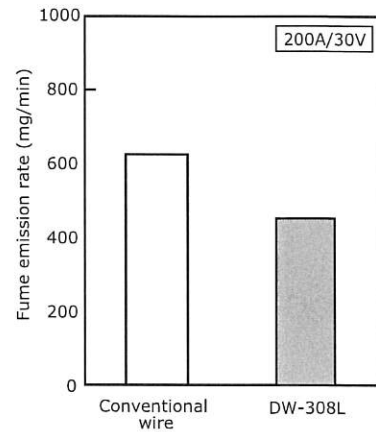


Figure 2: A comparison between DW-308L and conventional flux-cored wire in terms of fume emission rate (Wire size: 1.2 mmØ, Shielding gas: 100%CO₂).

Convenient self-peeling slag removal and glossy bead appearance of DW-308L will leave you feeling very satisfied—Figures 3 and 4.

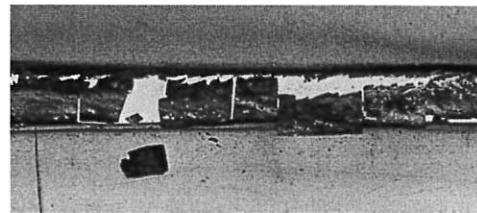


Figure 3: Excellent self-peeling slag removability of DW-308L.

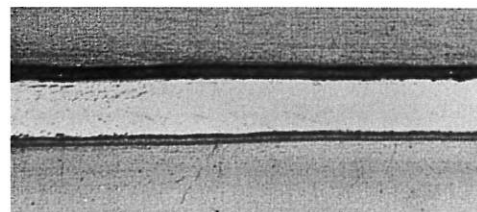


Figure 4: The glossy appearance of DW-308L fillet weld bead.