

PREMIARC™ DW-308LP [AWS A5.22 E308LT1-1/4]

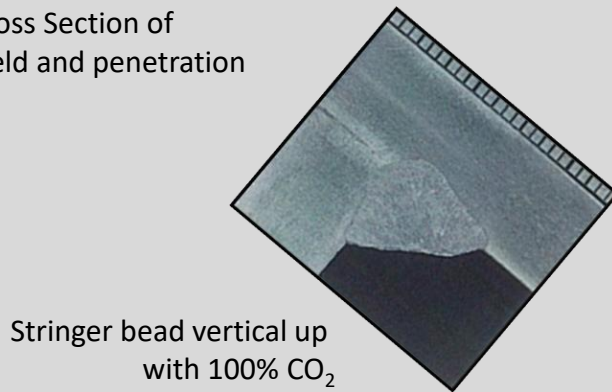
PREMIARC™ DW-309LP [AWS A5.22 E309LT1-1/4]

PREMIARC™ DW-316LP [AWS A5.22 E316LT1-1/4]

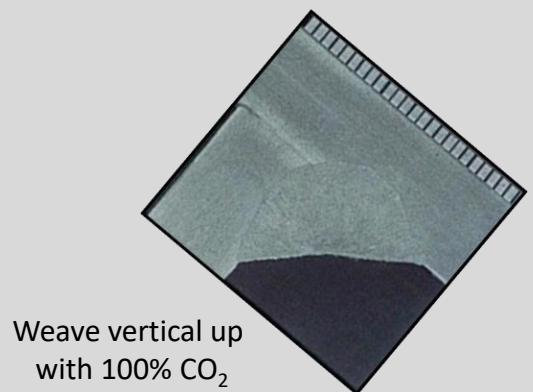
Features and typical fields of application

- These products were designed for all position welding of austenitic stainless steel
- Excellent performance in vertical upward position with either 75%Ar-25%CO₂ gas or 100%CO₂
- Flat bead profile with easy mig-gun operation in position as well as out of position contribute to high efficiency
- This product features a low fume emission formula which creates a clean welding environment at any welding condition.

Cross Section of weld and penetration



Stringer bead vertical up with 100% CO₂



Weave vertical up with 100% CO₂

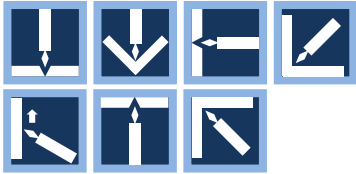
Typical chemical composition of weld metal per AWS A5.22

	Shielding Gas	C	Si	Mn	Cr	Ni	Mo	FNW*
DW-308LP	100%CO ₂	0.02	0.69	1.55	19.5	10.0	Tr.	10
DW-309LP		0.02	0.45	1.34	23.3	12.6	Tr.	20
DW-316LP		0.02	0.46	1.39	19.0	12.6	2.2	9

*: Ferrite Number by WRC Diagram (1992)

Typical mechanical properties of weld metal per AWS A5.22

	Shielding Gas	0.2% PS (ksi)	TS (ksi)	El (%)
DW-308LP	100%CO ₂	60	78	40
DW-309LP		60	79	41
DW-316LP		61	82	36



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Approval

CWB, LR, DNV-GL

Recommended welding conditions and deposition rate

Wire Dia.	Wire Feed Speed (in/min)	Welding Current (A)	Arc Voltage (V)	Deposition Rate (lbs/hr)	Wire Stick-Out	Shielding Gas Flow Rate (CFH)
0.035"	205	90	23-25	2.5	1/2	35-45
	250	100	24-26	3.0		
	280	110	25-27	3.3		
	330	120	25-28	3.9		
	375	130	27-29	4.5		
	460	140	28-30	5.5		
0.045"	550	150	29-31	6.6	5/8-3/4"	40-50
	210	130	24-26	5.0		
	275	155	25-27	6.0		
	330	175	26-28	6.8		
	380	190	27-29	8.0		
	440	210	28-30	9.5		
1/16"	540	230	28-31	10.6	3/4"-1"	40-50
	610	250	30-33	12.0		
	160	190	28-30	6.5		
	195	210	29-31	8.0		
	220	230	29-31	8.5		
	250	260	31-33	9.5		
280	270	31-33	11.0			
320	300	31-34	12.0			
350	320	31-35	13.5			

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.). Arc voltage shown are for straight CO₂ shielding gas. For 75%Ar-25%CO₂ use two volts less than shown.

Available Products

Wire Dia.	0.035", 0.045", 1/16"	Package	28 lbs spool
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DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

KOBELCO WELDING OF AMERICA INC.

