



Environmental-friendly Wires

PREMIARC™
DW-308L-XR / E308LT0-1/4

PREMIARC™
DW-309L-XR / E309LT0-1/4

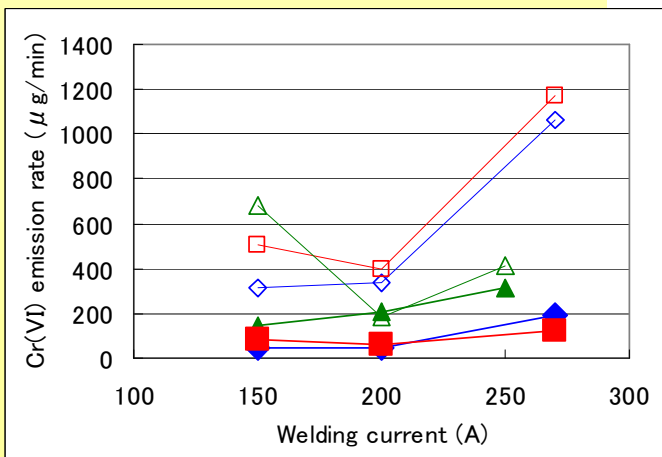
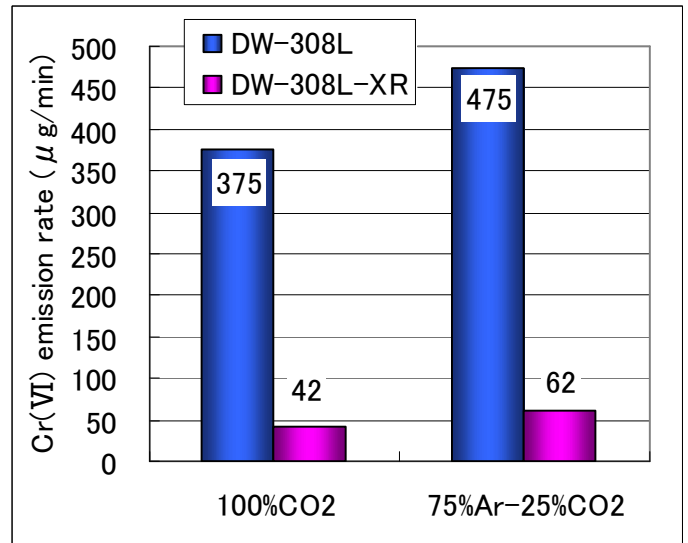
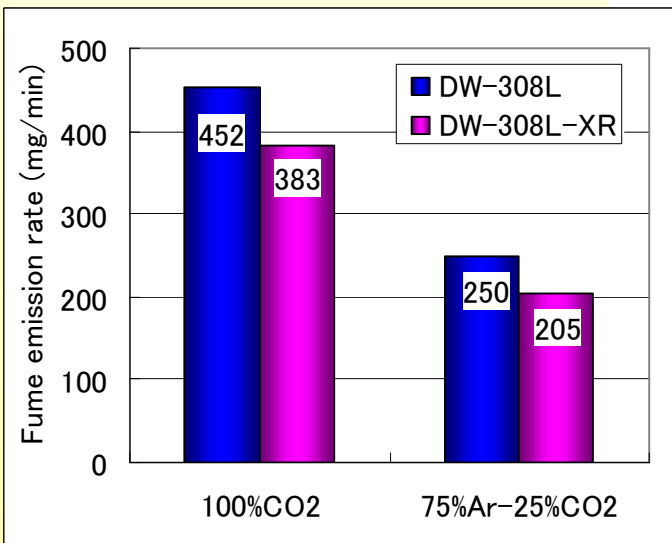
PREMIARC™
DW-316L-XR / E316LT0-1/4



Outstanding Features

- Our XR-series wires have reduced the Hexavalent Cr production in the welding fume over conventional wires.
- This reduction contributes to a safer environment by reducing the potential exposure to Hexavalent Cr in the workplace.
- 75%Ar-25%CO₂ gas mixture or 100%CO₂. (75%Ar-25%CO₂ recommended)

Occupational Safety and Health Administration (OSHA) decides that exposure limit of Cr(VI) is 0.005mg/m³



- ◆ FCAW (E308LT, 100%CO₂)
- FCAW (E308LT, 75%Ar-25%CO₂)
- △ GMAW (ER308, 98%Ar-2%O₂)
- ▲ GMAW Pulse (ER308, 98%Ar-2%O₂)
- ◆ FCAW (DW-308L-XR, 100%CO₂)
- FCAW (DW-308L-XR, 75%Ar-25%CO₂)

Typical chemistry of weld metal (0.045" Dia. 75%Ar-25%CO₂)

Alloy	C	Si	Mn	Cr	Ni	Mo	FN
DW-308L-XR	0.03	0.74	1.29	19.4	9.5	-	11
DW-309L-XR	0.03	0.82	1.36	24.4	12.1	-	23
DW-316L-XR	0.03	0.74	1.28	18.9	12.0	2.4	9

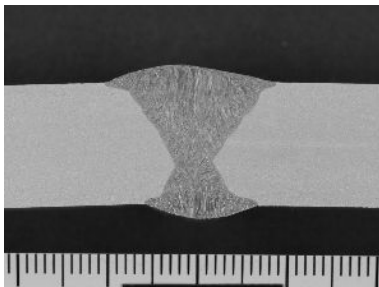
FN=Ferrite Number by WRC Diagram (1992)

Typical mechanical property of weld metal (0.045" Dia. 75%Ar-25%CO₂)

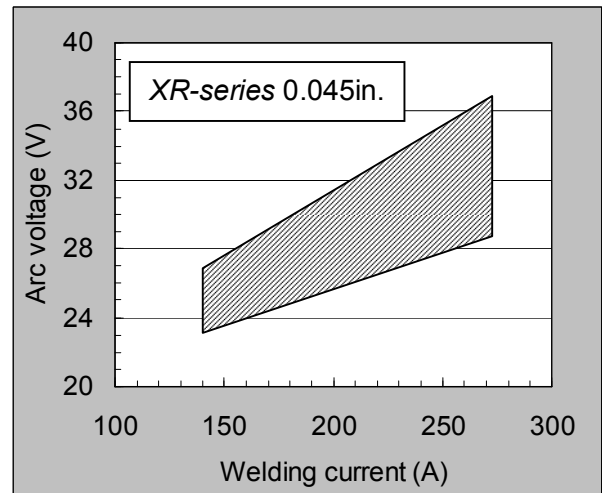
Alloy	0.2%P.S (psi)	T.S (psi)	Elongation (%)
DW-308L-XR	57,400	84,600	40
DW-309L-XR	69,300	94,300	33
DW-316L-XR	58,000	79,500	42

Test method: AWS A5.22, welding parameter: 200A-29V (0.045")

【Bead appearance and Macro cross section】



DW-308L-XR 0.045"
200A-29V
75%Ar-25%CO₂



**Recommended Welding Conditions
(75%AR-25%CO₂)**