



# Stainless Flux Cored Wires

## Outstanding Features

**PREMIARC**

DW-308L / E308LT0-1/4

**PREMIARC**

DW-309L / E309LT0-1/4

**PREMIARC**

DW-316L / E316LT0-1/4



- Excellent performance in flat and horizontal position with either 75%Ar-25%CO<sub>2</sub> gas mixture or 100%CO<sub>2</sub>.
- Easy slag removal greatly reduces the cleaning time after welding.
- Due to less spattering and small spatter size, adhesion of spatter to the base metal is almost eliminated

◆ Conform to AWS, ASME and CWB classification

◆ 0.035, 0.045" and 1/16" with 28Lbs spool are available

### Typical chemistry of weld metal (0.045" Dia. 100%CO<sub>2</sub>)

Alloy	C	Si	Mn	Cr	Ni	Mo	FN
DW-308L	0.03	0.54	1.45	19.39	9.91	-	9.2
DW-309L	0.03	0.51	1.23	23.95	12.66	-	19.2
DW-316L	0.03	0.49	1.35	18.94	12.02	2.21	7.1

FN=Ferrite Number by WRC Diagram (1992)

### Typical mechanical property of weld metal (0.045" Dia. 100%CO<sub>2</sub>)

Alloy	0.2%P.S (psi)	T.S (psi)	Elongation (%)
DW-308L	61,132	78,898	42
DW-309L	60,907	81,218	34
DW-316L	57,521	81,800	37

Test method: AWS A5.22, welding parameter: 200A-28V (0.045")

### [Bead appearance]

DW-308L 0.045"  
200A-27V  
75%Ar-25%CO<sub>2</sub>





**PREMARC** DW-308L

AWS A5.22 E308LT0-1, -4

**PREMARC** DW-309L

AWS A5.22 E309LT0-1, -4

**PREMARC** DW-316L

AWS A5.22 E316LT0-1, -4

**Recommended welding parameters and deposition rate**

Wire size (in.)	Wire feeding speed (in./min)	Current (A)	Voltage (V)	Deposition rate (lbs/hr)
0.045	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
	540	230	28-31	10.6
	610	250	30-33	12.0
1/16	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	32-35	13.5

Tables shown are approximate values that will vary depending on welding conditions(WESO, Cable length etc.).

Voltages shown are for 100%CO<sub>2</sub> shielding gas. For 75%Ar-25%CO<sub>2</sub> use two volts less than shown.

\*DC-Electrode positive \*\*Arc voltage is measured at wire feeder.

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