PREMIARC™

DW-309LP

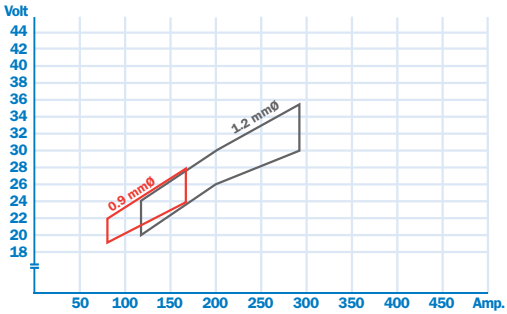
80%Ar - 20%CO_2 / 100%CO_2
EN ISO 17633-A T 23 12 L P C1/M21 1
AWS A5.22 E309LT1-1/4
EN 1.4332

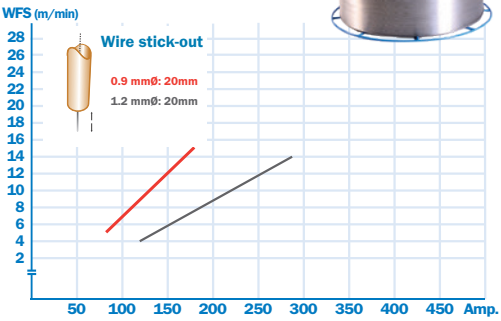
Description and Application

This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces and self releasing slag.

This wire deposits a low carbon weld of about 24%Cr-13%Ni. It is designed for dissimilar welding such as welding stainless steel to mild steel or low alloy steel. The wire is also suitable for the first layer on mild or low alloy steel prior to overlaying with **DW-308L** or **DW-308LP.**

Recommended Parameter Range, for flat position*





Typical Chemical Analysis (wt. %)*

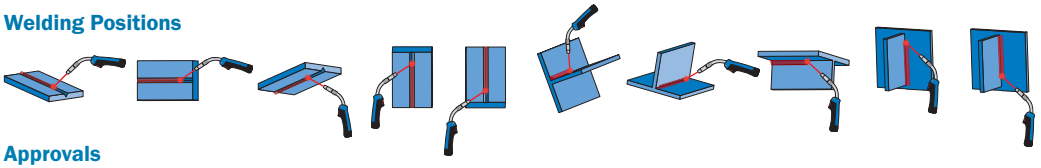
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.42	0.80	0.017	0.005	12.6	23.2	-	-	-	11.7	17.0	14.7

Typical Mechanical Properties*

	R_e(MPa)	R_m(MPa)	A_5(%)	CV(J)+20°C	CV(J)-20°C
	410	580	41	60	52
Guaranty	min.320	min.520	min.25		

* The above values and parameters are for all weld metal produced using Ar+CO_2 shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
SS/CMn	VL 309 L	309L	E309LT1-1/4	A-9sp	TÜV,DB,CWB, RINA