

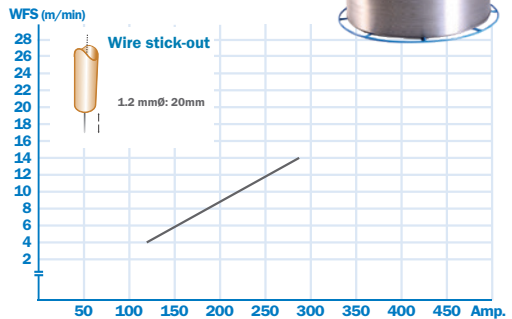
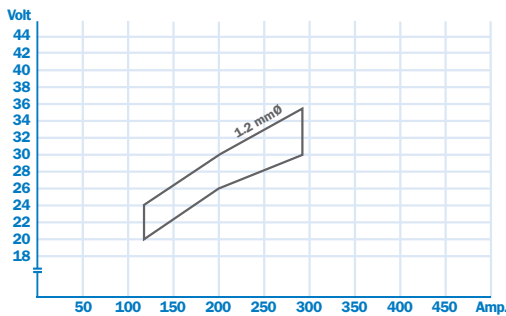
Description and Application

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

This wire deposits low carbon weld metal of about 23%Cr-13%Ni-2.3%Mo and is designed for dissimilar welding such as welding stainless steel to mild or low alloy steel. This wire is also suitable for the first layer welding on mild steel or low alloy steel prior to overlaying with **DW-316L/LP** or **DW-317L**.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

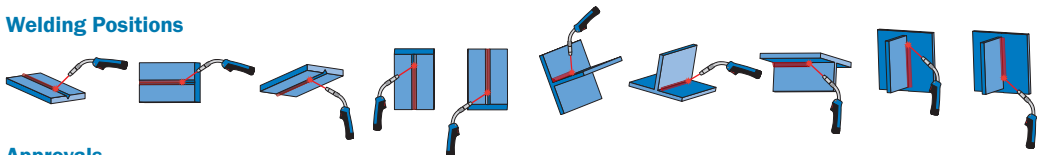
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.60	0.90	0.018	0.006	12.5	22.5	2.3	-	-	16.6	>18.0	24.4

Typical Mechanical Properties*

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)+20°C	CV(J)-20°C
Guaranty	530	690	31	62	51
	min.350	min.550	min.25		

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
SS/CMn	VL 309 MoL	309MoL	-	-	-