

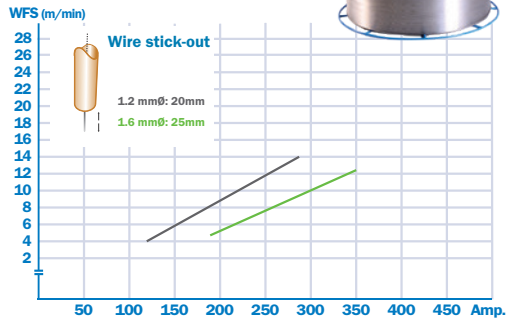
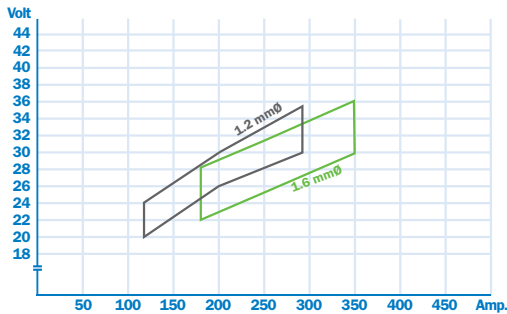
## Description and Application

This wire is a rutile flux cored wire that operates with a very stable spatter free arc.

**DW-309LH** is applied for high temperature applications where a high resistance to oxidation is required, like industrial furnaces (ovens). This wire is usually used as the buffer layer for overlay welding prior to overlaying with **DW-308H**.



### Recommended Parameter Range, for flat position\*



### Typical Chemical Analysis (wt. %)\*

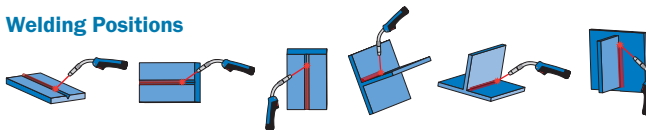
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.02	0.49	1.38	0.024	0.004	12.7	23.7	-	-	-	12.1	>18	19.1

### Typical Mechanical Properties\*

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)+20°C	CV(J)0°C
Guaranty	406	578	31	76	73
	min.320	min.520	min.30		

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-