



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%CO₂ gas mixture or 100%CO₂.
- 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

◇ 0.045" and 1/16" with 28Lbs spool are available

Typical chemistry of weld metal (0.045" Dia. 100%CO₂)

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%CO₂)

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%CO₂





PREMIARC™ DW-308L

AWS A5.22 E308LT0-1, -4

PREMIARC™ DW-309L

AWS A5.22 E309LT0-1, -4

PREMIARC™ 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%CO₂ shielding gas. For 75%Ar-25%CO₂ use two volts less than shown.

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



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

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