



## Environmental-Friendly

# LP-XR Series

**PREMIARC™**  
**DW-308LP-XR / E308LT1-1/4**

**PREMIARC™**  
**DW-309LP-XR / E309LT1-1/4**

**PREMIARC™**  
**DW-316LP-XR / E316LT1-1/4**

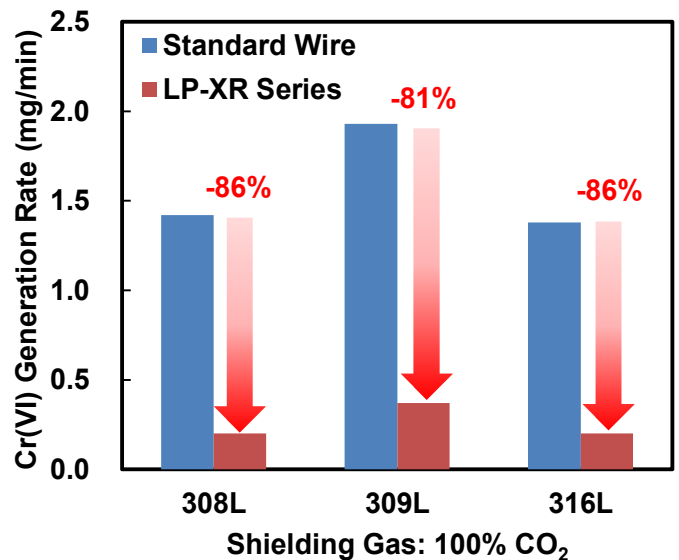
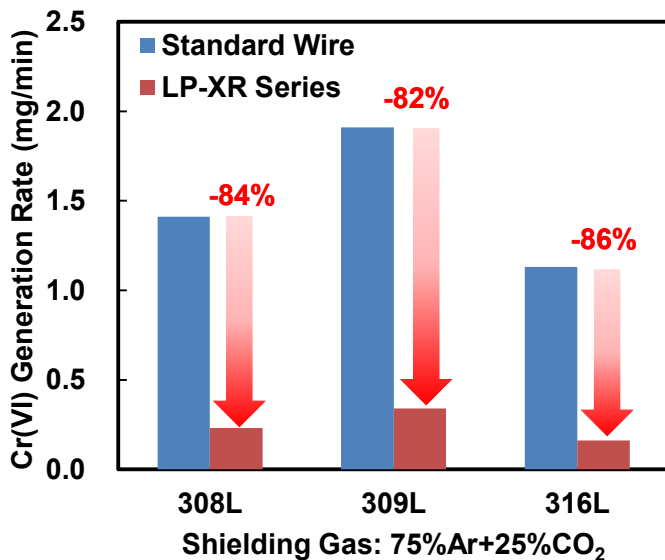


### Outstanding Features

- LP-XR-series wires have reduced the Hexavalent Cr production in the welding fume over conventional wires.
- This reduction contributes to a safer environment by reducing the potential exposure to Hexavalent Cr in the workplace.
- All position welding can be achieved with 75%Ar+25%CO<sub>2</sub> gas mixture and 100% CO<sub>2</sub>.
- Flatter bead shape is guaranteed with easy torch operation in vertical position as well as horizontal position.

Occupational Safety and Health Administration (OSHA) reduces that exposure limit of Cr(VI) to 0.005mg/m<sup>3</sup>

### ■ Hexavalent Cr Generation Rate



■ **Typical chemistry of weld metal (0.045" 75%Ar+25%CO<sub>2</sub>)**

Alloy	C	Si	Mn	Ni	Cr	Mo	FN
DW-308LP-XR	0.03	0.82	1.79	10.4	19.5	0.02	8
DW-309LP-XR	0.03	0.67	0.95	12.3	24.2	0.02	22
DW-316LP-XR	0.03	0.75	1.19	12.5	19.0	2.8	9

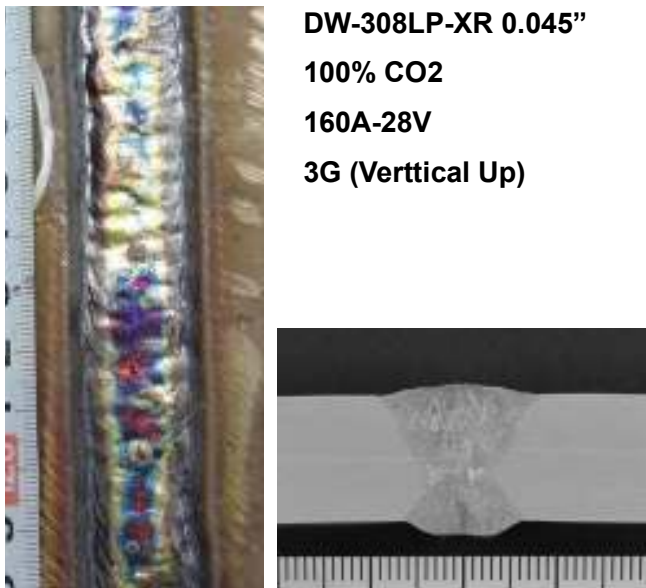
FN=Ferrite Number by WRC Diagram (1992)

■ **Typical mechanical property of weld metal (0.045" 75%Ar+25%CO<sub>2</sub>)**

Alloy	0.2% P.S. (psi)	T.S. (psi)	El. (%)	R.A. (%)
DW-308LP-XR	56,000	79,900	42	48
DW-309LP-XR	62,400	81,500	37	46
DW-316LP-XR	62,200	82,000	41	50

Test method: AWS A5.22, welding parameter: 200A-29V (0.045")

■ **Bead appearance & Cross section**



■ **Recommended Welding Parameters (75%Ar+25%CO<sub>2</sub>)**

