

PREMIARC™

DW-308L-XR / E308LT0-1/4

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DW-309L-XR / E309LT0-1/4

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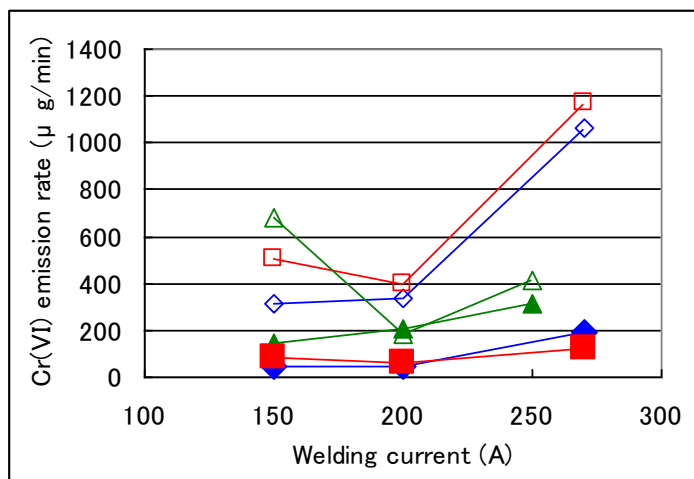
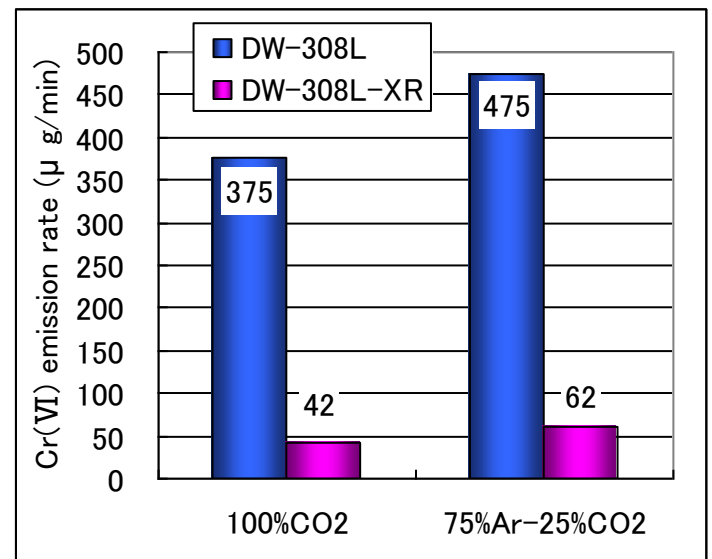
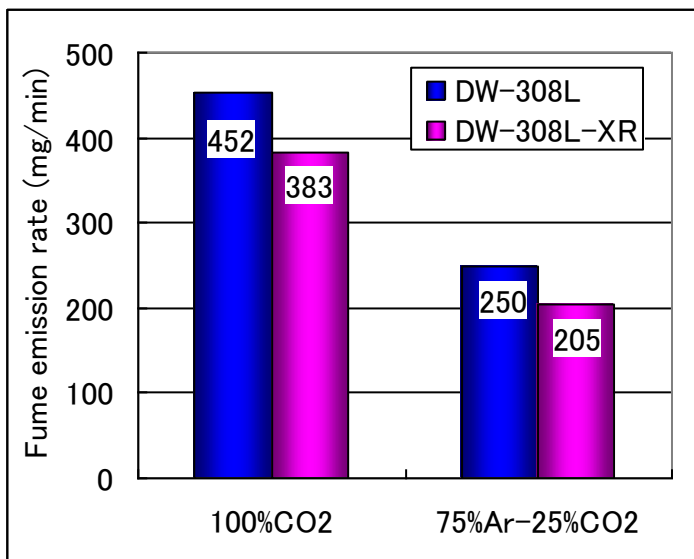
DW-316L-XR / E316LT0-1/4



Outstanding Features

- Our 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.
- 75%Ar-25%CO₂ gas mixture or 100%CO₂. (75%Ar-25%CO₂ recommended)

Occupational Safety and Health Administration (OSHA) reduces that exposure limit of Cr(VI) to 0.005mg/m³



- ◇— FCAW (E308LT, 100%CO₂)
- FCAW (E308LT, 75%Ar-25%CO₂)
- △— GMAW (ER308, 98%Ar-2%O₂)
- ▲— GMAW Pulse (ER308, 98%Ar-2%O₂)
- ◆— FCAW (DW-308L-XR, 100%CO₂)
- FCAW (DW-308L-XR, 75%Ar-25%CO₂)

Typical chemistry of weld metal (0.045" Dia. 75%Ar-25%CO₂)

Alloy	C	Si	Mn	Cr	Ni	Mo	FN
DW-308L-XR	0.03	0.74	1.29	19.4	9.5	-	11
DW-309L-XR	0.03	0.82	1.36	24.4	12.1	-	23
DW-316L-XR	0.03	0.74	1.28	18.9	12.0	2.4	9

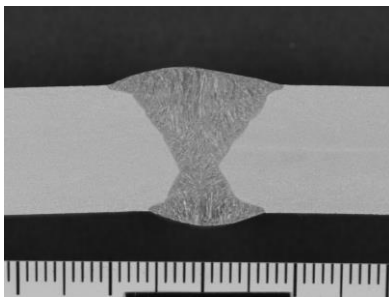
FN=Ferrite Number by WRC Diagram (1992)

Typical mechanical property of weld metal (0.045" Dia. 75%Ar-25%CO₂)

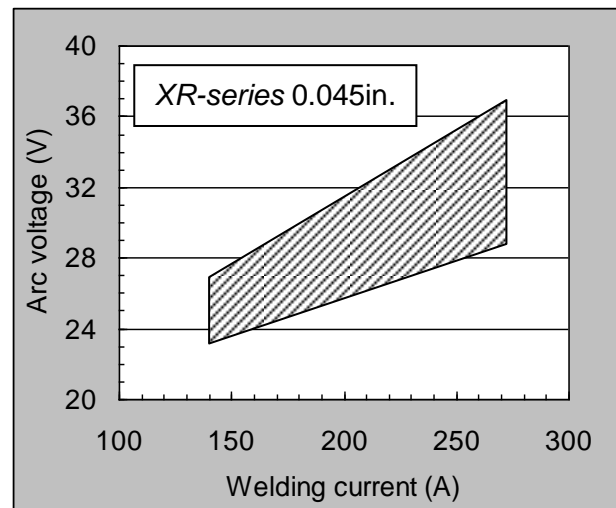
Alloy	0.2%P.S (psi)	T.S (psi)	Elongation (%)
DW-308L-XR	57,400	84,600	40
DW-309L-XR	69,300	94,300	33
DW-316L-XR	58,000	79,500	42

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

[Bead appearance and Macro cross section]



DW-308L-XR 0.045"
 200A-29V
 75%Ar-25%CO₂



**Recommended Welding Conditions
 (75%AR-25%CO₂)**



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.P65Warning.ca.gov.

July 2018