



DW-309L

**Classification: AWS A5.22 E309LT0-1
AWS A5.22 E309LT0-4**

All-Weld-Metal (100%CO₂)

1-1. Chemical Composition

[Unit: mass%]

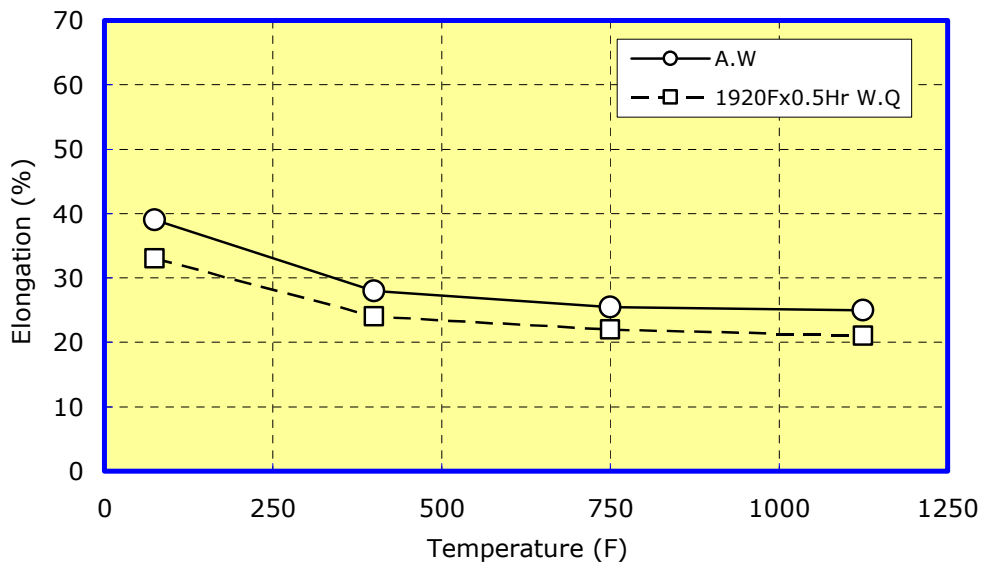
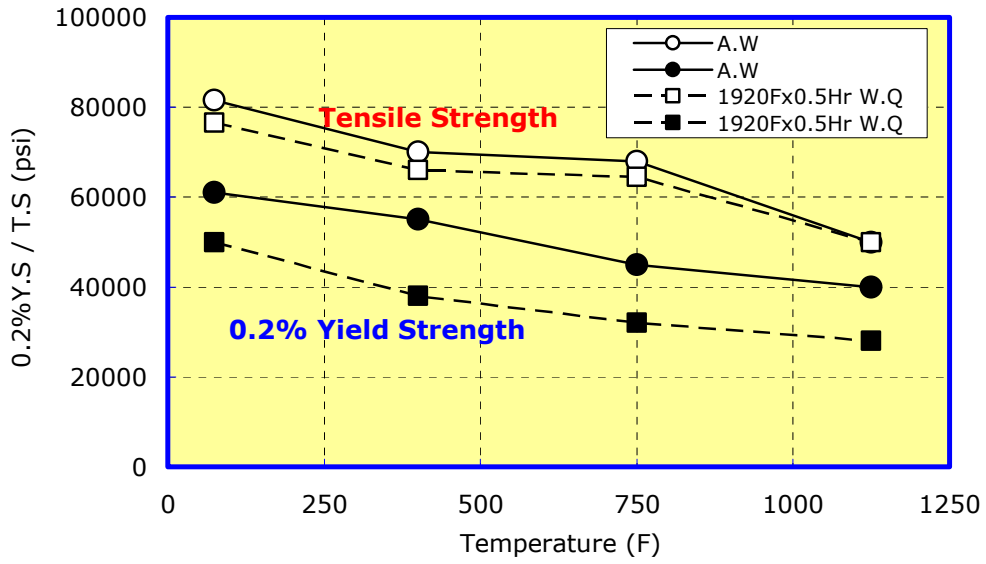
	C	Mn	Si	P	S	Ni	Cr	N
DW-309L	0.03	1.24	0.48	0.016	0.011	12.49	23.73	0.018
E309LT0-X	<0.04	0.5~2.5	<1.0	<0.04	<0.03	12.0~14.0	22.0~25.0	-----
	WRC-1992 (FN)		Shaeffler Diagram (%)		Delong Diagram (FN)			
DW-309L	19.2		12.6		>18			
E309LT0-X	-----		-----		-----			

1-2. Tensile Test

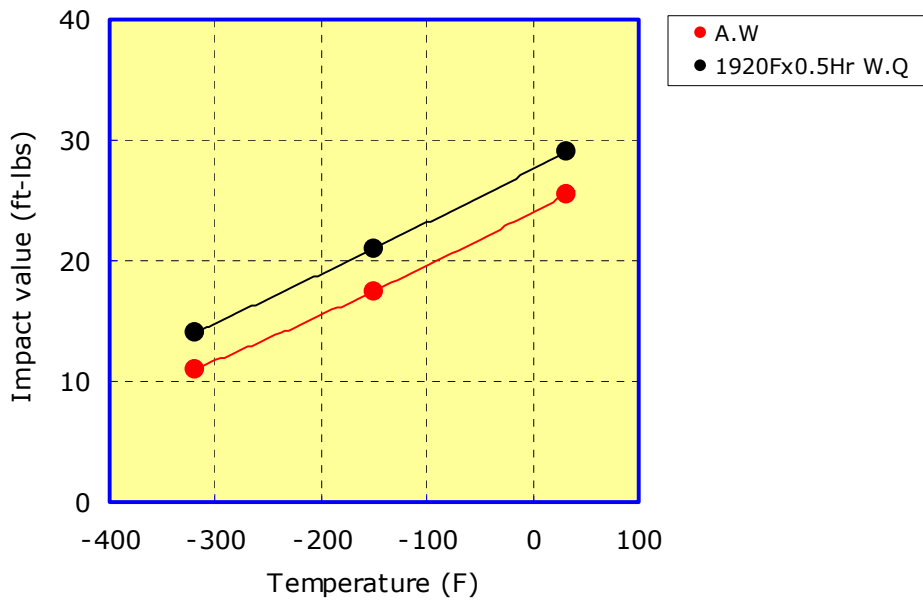
	0.2% Proof stress (psi)	Tensile strength (psi)	Elongation (%)	Reduction of Area (%)
DW-309L	60,907	81,218	34	42
E309LT0-X	---	>75,000	>30	---

Note) Test was completed in the as welded condition and at room temperature

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1-3. Impact Test



1-4. Corrosion Test

Huey Test

PWHT	Test results (IPM)			
	1 st	2 nd	3 rd	Ave.
As Welded	0.00032	0.00029	0.00035	0.00032

Huey Test (65% Nitric Acid Test)

Welding Journal, Oct. 1951 "Corrosion Data of Welding Low Carbon Stainless Steel"

- Excellent < 0.0009 IPM
- Good < 0.0009 – 0.0021 IPM
- Fair < 0.0021 – 0.0042 IPM
- Poor > 0.0042 IPM



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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