



PREMIARC™ DW-308L-XR [AWS A5.22 E308LT0-1/4]

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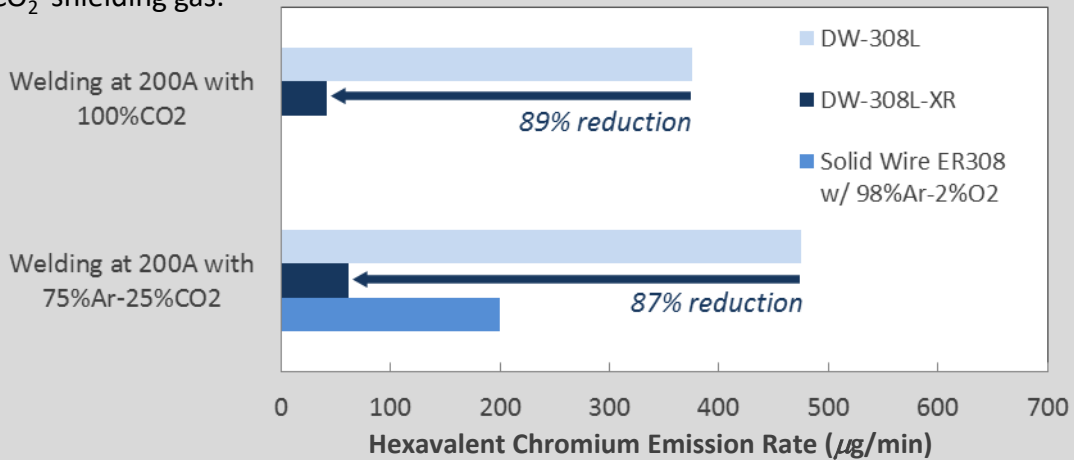
PREMIARC™ DW-316L-XR [AWS A5.22 E316LT0-1/4]

Features and typical fields of application

- This product line has been designed for flat and horizontal position welding of austenitic stainless steel with reduced hexavalent chromium emission in its welding fume over conventional wires.
- The reduction of the emission contributes to a safer environment by reducing the potential exposure to hexavalent chromium in your shop or working environment.

Note: Occupational Safety and Health Administration (OSHA) requires the exposure limit of hexavalent chromium less than 0.005mg/m³

- Excellent performance in the flat and horizontal positions with either 75%Ar-25%CO₂ gas or 100%CO₂ shielding gas.



Typical chemical composition of weld metal per AWS A5.22

	Shielding Gas	C	Si	Mn	Cr	Ni	Mo	FNW*
DW-308L-XR	75%Ar-25%CO ₂	0.03	0.74	1.29	19.4	9.5	Tr.	11
DW-309L-XR		0.03	0.82	1.36	24.4	12.1	Tr.	23
DW-316L-XR		0.03	0.74	1.28	18.9	12.0	2.4	9

*: Ferrite Number by WRC Diagram (1992)

Typical mechanical properties of weld metal per AWS A5.22

	Shielding Gas	0.2% PS (ksi)	TS (ksi)	El (%)
DW-308L-XR	75%Ar-25%CO ₂	57	85	40
DW-309L-XR		69	94	33
DW-316L-XR		58	80	42



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Approval

CWB

Recommended welding conditions and deposition rate

Wire Dia.	Wire Feed Speed (in/min)	Welding Current (A)	Arc Voltage (V)	Deposition Rate (lbs/hr)	Wire Stick-Out	Shielding Gas Flow Rate (CFH)
0.045"	210	130	24-26	5.0	5/8-3/4"	40-50
	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		

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.). Arc voltage shown are for straight CO₂ shielding gas. For 75%Ar-25%CO₂ use two volts less than shown.

Available Products

Wire Dia.	0.045"	Package	28 lbs spool
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DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



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.

KOBELCO WELDING OF AMERICA INC.



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