

 **KOBELCO FCW Data Sheet 2**

DW-308

Classification : AWS A5.22 E308T0-1, E308TO-4

AWS A5.22 E308HT0-I*, E308HT0-4*

* (Not printed on box and label)

Note :DW-308 is not recommended for service temperatures above 1,200°F.
For service temperatures above 1,200°F, DW-308H is recommended.

All-Weld-Metal (1 00%CO2)

2-1. Chemical Composition

Unit : wt%

	C	Mn	Si	P	S	Ni	Cr	N
DW-308	0.06	1.51	0.45	0.018	0.011	9.62	20.07	0.015
E308TX-X	≤ 0.08	0.5/2.5	≤ 1.0	≤ 0.04	≤ 0.03	9.0/11.0	18.0/21.0	---

2-2. Ferrite Content

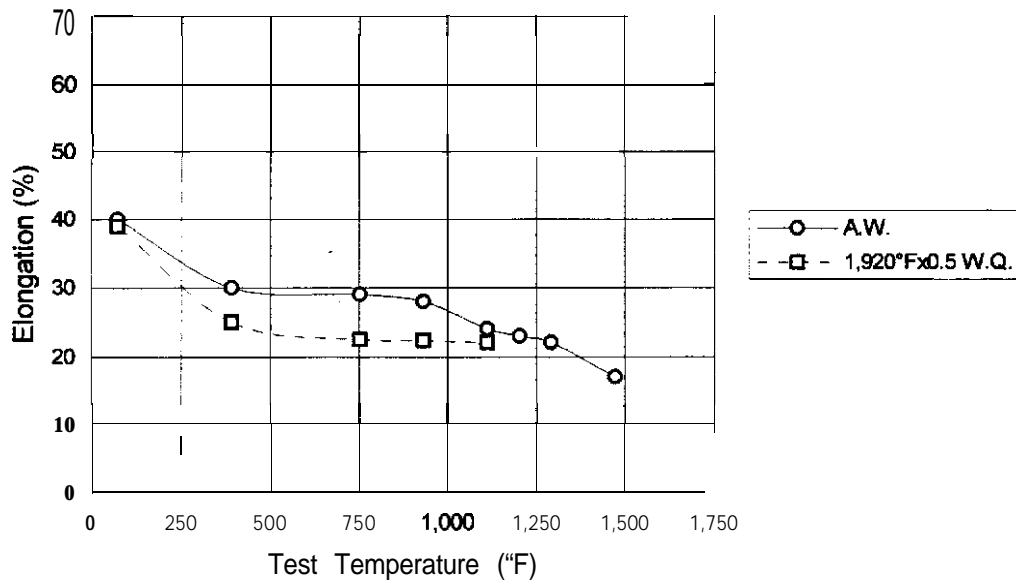
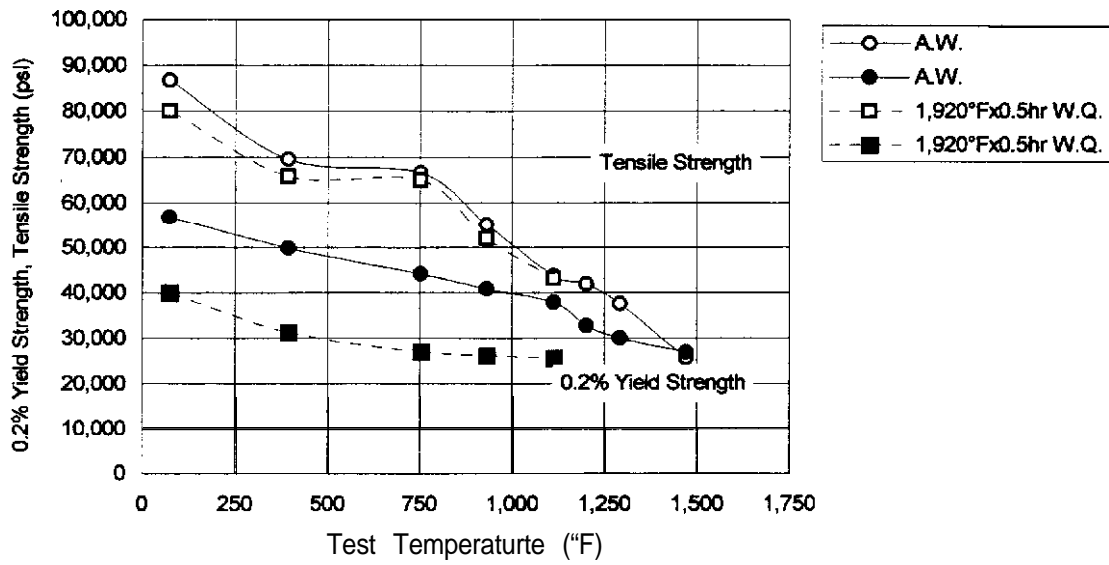
	Shaeffler Diagram %	Delong Diagram (FN)	1992- WRC Diagram (FN)
As Welded	7.9	11.4	9.5

2-3. Tensile Test

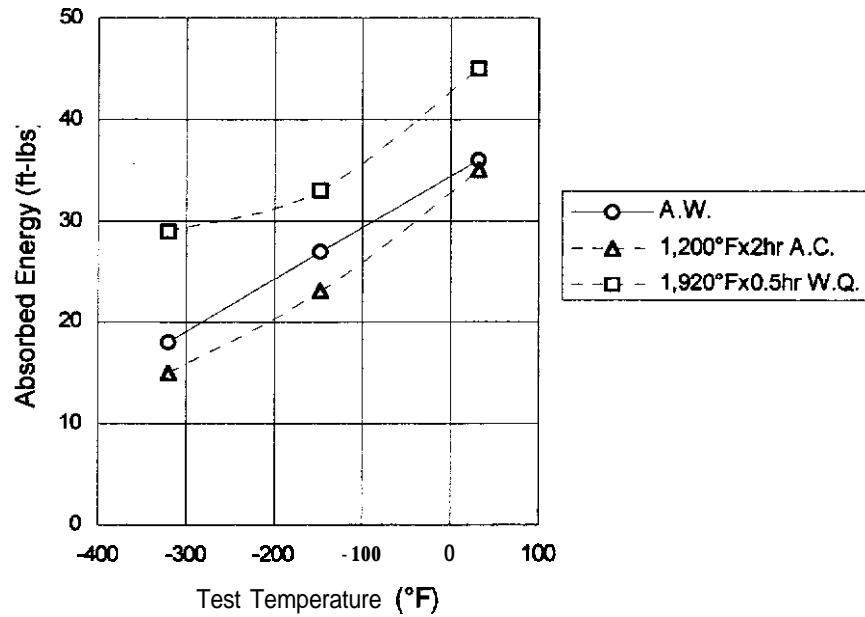
	0.2% Yield Strength (psi)	Tensile Strength (psi)	Elongation (%)	Reduction of Area %
DW-308	56,806	86,729	40	44
E308TX-X	---	180,000	≥ 35	—

Note: Test was completed in the as-welded condition at room temperature.

2-4. High Temperature Strength



2-5. impact Test



2-6. Corrosion Test

PWHT	Test Results (IPM)			
	1st	2nd	3rd	Avg.
As Welded	0.00066	0.00066	0.00062	0.00071
1,200°F x 2hr*	0.00096	0.00104	0.00111	0.00104
1,920°F x 0.5hr**	0.00046	0.00037	0.00043	0.00043

Note: *Air cooled

 "Water quenched

 Huey Test (65% Nitric Acid Test)

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

 Excellent <0.0009 IPM

 G o o d <0.0009 - 0.0021 IPM

 Fair <0.0021 - 0.0042 IPM

 Poor >0.0042 IPM