

**KOBELCO FCW Data Sheet 7**

**DW-309L**

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

**All-Weld-Metal (100% CO<sub>2</sub>)**

**7-1. Chemical Composition**

Unit : wt%

	C	Mn	Si	P	S	Ni	Cr	N
DW-309L	0.025	1.24	0.48	0.016	0.011	12.49	23.73	0.018
E309LTX-X	≤0.04	0.5/2.5	≤1.0	≤0.04	≤0.03	12.0/14.0	22.0/25.0	---

**7-2. Ferrite Content**

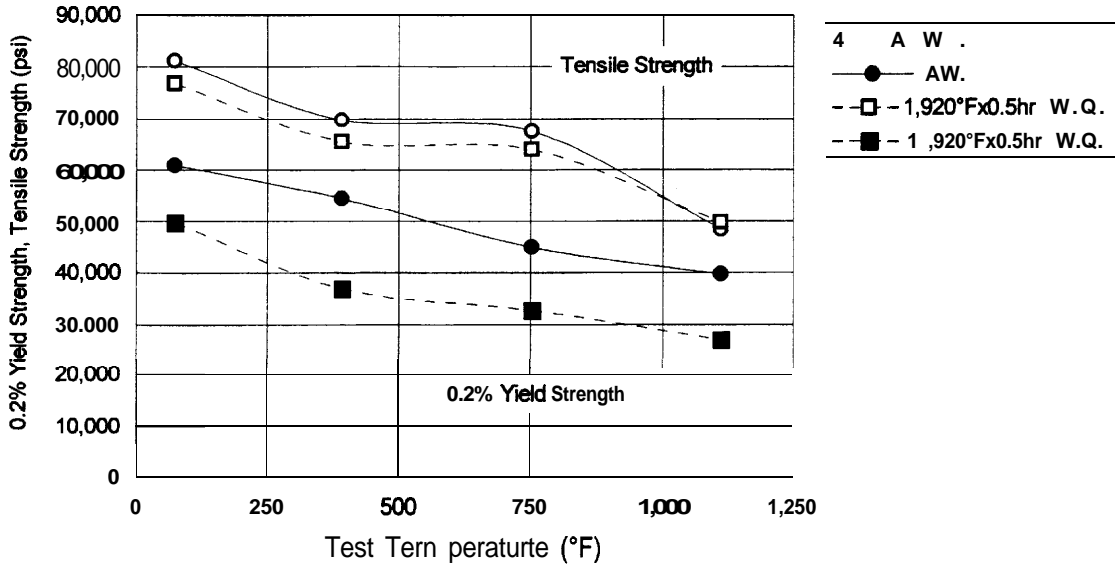
	Shaeffler Diagram (%)	DeLong Diagram (FN)	1992-WRC Diagram (FN)
As Welded	12.6	> 18	19.2

**7-3. Tensile Test**

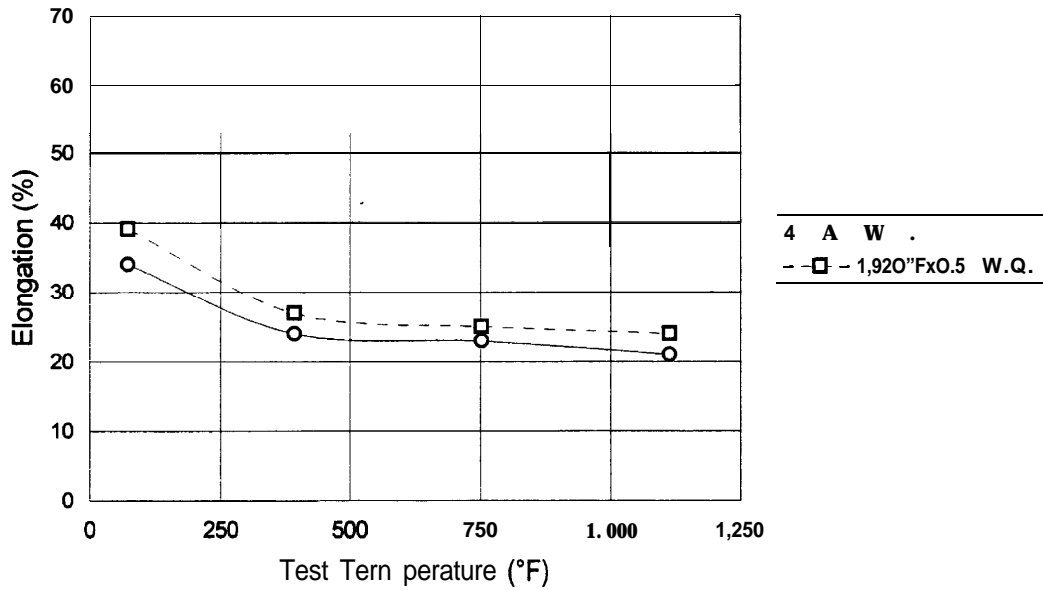
	0.2% Yield Strength (psi)	Tensile Strength (psi)	Elongation (%)	Reduction of Area (%)
DW-309L	60,907	81,218	34	42
E309LTX-X	---	275,000	≥30	---

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

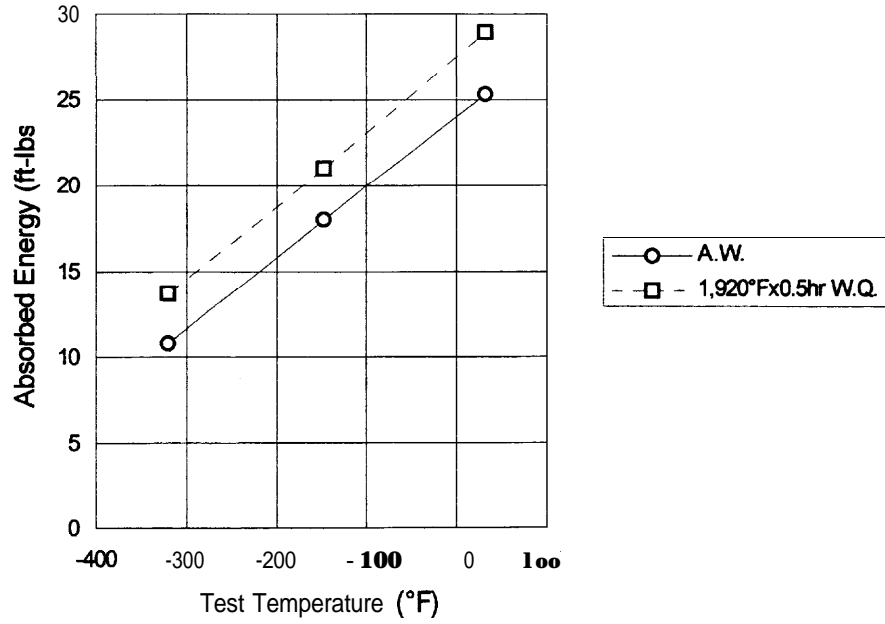
## 7-4. Tensile Strength and 0.2% Yield Strength



## Elongation



## 7-5. Impact Test



## 7-6. Corrosion Test

### Huey Test

	Test Results (IPM)			
	1st	2nd	3rd	Avg.
As Welded	0.00032	0.00029	0.00035	0.00032