


KOBELCO FCW Data Sheet 9
DW-309LMo**Classification : AWS A5.22 E309LMoT0-1****AWS A5.22 E309LMoTO-4****All-Weld-Metal (100% CO₂)****9-1. Chemical Composition****Unit : wt%**

	C	Mn	Si	P	S	Ni	Cr	Mo	N
DW-309LMo	0.023	1.44	0.55	0.021	0.012	13.42	22.03	2.85	0.011
E309LMoTX-X	≤ 0.04	0.5/2.5	≤ 1.0	10.04	≤ 0.03	12/16	21/25	2/3	---

9-2. Ferrite Content

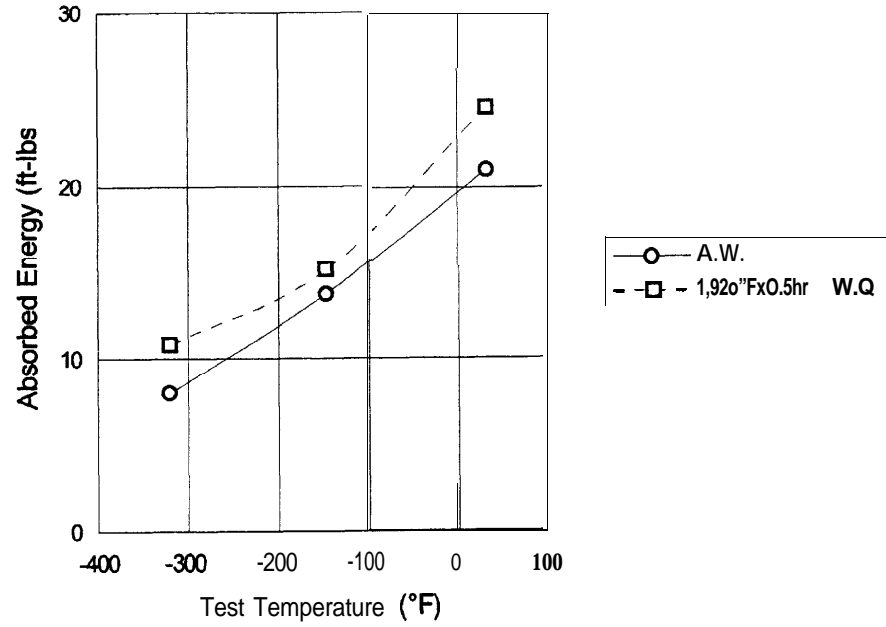
	Shaeffler Diagram (%)	DeLong Diagram (FN)	1992-WRC Diagram (FN)
As Welded	12.9	> 18	21.5

9-3. Tensile Test

	0.2% Yield Strength (psi)	Tensile Strength (psi)	Elongation (%)	Reduction of Area (%)
DW-309LMo	71,280	105,800	33	39
E309LMoTX-X	- - -	≥ 75,000	≥ 25	---

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

9-5. Impact Test

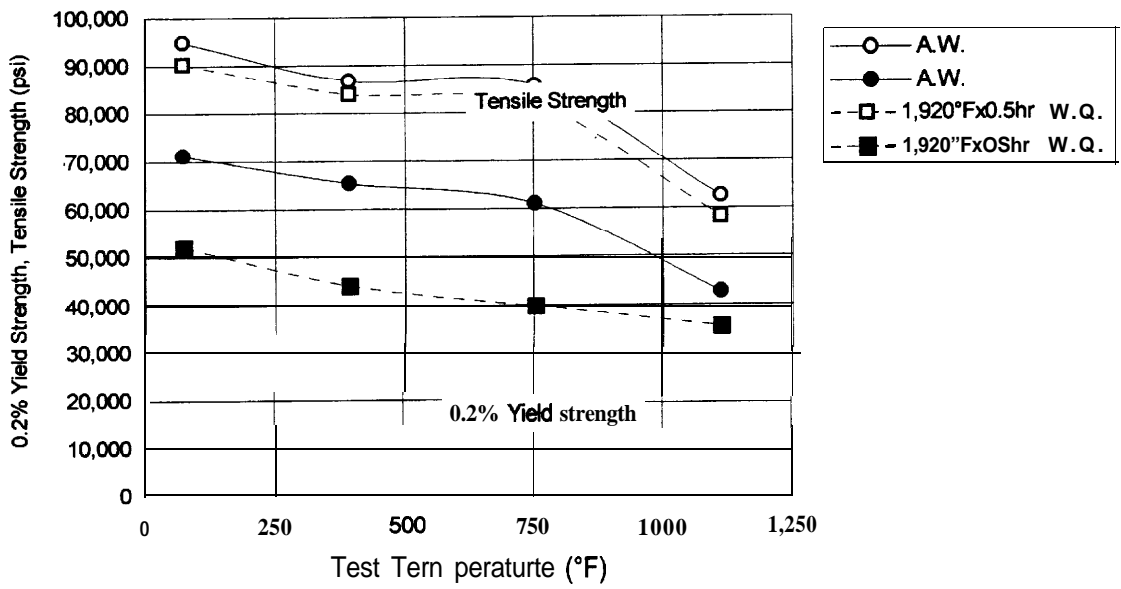


9-6. Corrosion Test

5% Sulfuric Acid Test

	Test Result (g/m ² •hr)
As Welded	3.4

9-4. Tensile Strength and 0.2% Yield Strength



Elongation

