


KOBELCO FCW Data Sheet 8
DW-309LP

**Classification : AWS A5.22 E309LT1-1
AWS A5.22 E309LT1-4**

All-Weld-Metal (100% CO₂)**8-1. Chemical Composition**

Unit : wt%

	C	Mn	Si	P	S	Ni	Cr	N
DW-309LP	0.021	0.80	0.42	0.017	0.005	12.59	23.24	0.039
E309LTX-X	10.04	0.5/2.5	≤1.0	≤0.04	≤0.03	12.0/14.0	22.0/25.0	---

8-2. Ferrite Content

	Shaeffler Diagram (%)	Delong Diagram (FN)	1992-WRC Diagram (FN)
As Welded	11.7	17.0	14.7

8-3. Tensile Test

	0.2% Yield Strength (psi)	Tensile Strength (psi)	Elongation (%)	Reduction of Area (%)
DW-309LP	59,056	79,188	42	51
E309LTX-X	---	≥75,000	≥30	---

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

8-4. Impact Test

