



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

**PREMIARC DW-309L** [AWS A5.22 E309LT0-1/4]

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

## Features and typical fields of application

- These products were designed for flat and horizontal welding of austenitic stainless steel
- High resistance to intergranular corrosion which comes from its low carbon content weld metal
- Excellent performance with either 75%Ar-25%CO<sub>2</sub> gas or 100%CO<sub>2</sub>
- Easy slag removal greatly reduces the cleaning time after welding.
- This product features a low fume emission formula which creates a clean welding environment at any welding condition.

### Bead appearance



DW-308L, 0.045" with 75%Ar-25%CO<sub>2</sub> gas

## Typical chemical composition of weld metal per AWS A5.22 w/100%CO<sub>2</sub>

	C	Si	Mn	Cr	Ni	Mo	FNW*
DW-308L	0.03	0.54	1.45	19.39	9.91	Tr.	9.2
DW-309L	0.03	0.51	1.23	23.95	12.66	Tr.	19.2
DW-316L	0.03	0.49	1.35	18.94	12.02	2.21	7.1

## Typical mechanical property of weld metal per AWS A5.22 w/100%CO<sub>2</sub>

	0.2% P.S. (psi)	T.S. (psi)	EL. (%)
DW-308L	61,132	78,898	42
DW-309L	60,907	81,218	34
DW-316L	57,521	81,800	37



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### Approval

ABS, CWB, LR, DNVGL

### Packages

Wire Dia. 0.045", 1/16"

Package 28Lbs plastic spool

### 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		
1/16"	160	190	28-30	6.5	3/4"-1"	40-50
	195	210	29-31	8.0		
	220	230	29-31	8.5		
	250	260	31-33	9.5		
	280	270	31-33	11.0		
	320	300	31-34	12.0		
	350	320	31-35	13.5		

Table shown are approximate values that will vary depending on welding conditions (WESO, Cable length etc.). Arc voltage shown are for straight CO<sub>2</sub> shielding gas. For 75%Ar-25%CO<sub>2</sub> use two volts less than shown.

#### 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](http://www.P65Warnings.ca.gov).

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