

## LP Series

**PREMIARC™**

**DW-308LP / E308LT1-1/4**

**PREMIARC™**

**DW-309LP / E309LT1-1/4**

**PREMIARC™**

**DW-316LP / E316LT1-1/4**



## Outstanding Features

- Excellent performance in vertical upward position with either 75%Ar-25%CO<sub>2</sub> gas mixture or 100%CO<sub>2</sub>.
- Flatter bead shape is guaranteed with easy torch operation in vertical position as well as horizontal position.
- LP series provide high productivity with less-fume and less-spatter which could minimize extra work time on post welding cleanup.

◇ Conform to AWS, ASME and CWB classification

◇ 0.035, 0.045" and 1/16" with 28Lbs spool are available

### Typical chemistry of weld metal (0.045" Dia. 100%CO<sub>2</sub>)

Alloy	C	Si	Mn	Cr	Ni	Mo	FN
DW-308LP	0.02	0.69	1.55	19.47	10.03	-	10.2
DW-309LP	0.02	0.45	1.34	23.33	12.55	-	19.9
DW-316LP	0.02	0.46	1.39	19.00	12.64	2.23	9.3

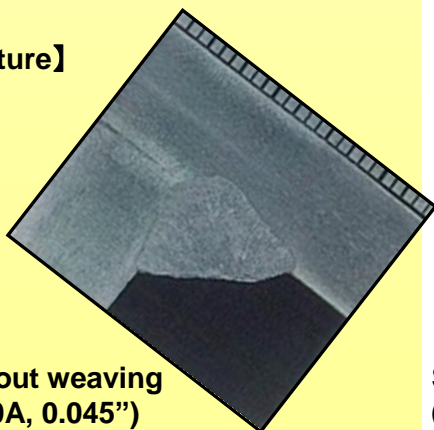
FN=Ferrite Number by WRC Diagram (1992)

### Typical mechanical property of weld metal (0.045" Dia. 100%CO<sub>2</sub>)

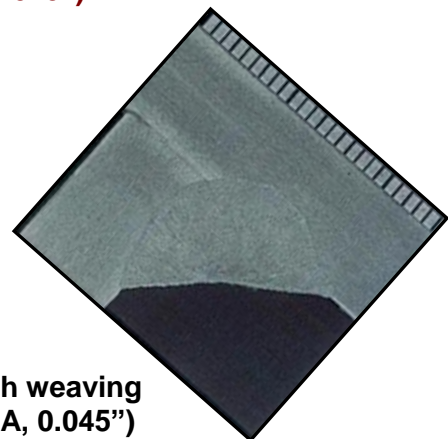
Alloy	0.2%P.S (psi)	T.S (psi)	Elongation (%)
DW-308LP	60,010	78,200	40
DW-309LP	59,990	78,875	41
DW-316LP	60,675	81,786	36

Test method: AWS A5.22, welding parameter: 200A-28V (0.045")

[Sectional structure]



Straight-up without weaving  
(100%CO<sub>2</sub>, 150A, 0.045")



Straight-up with weaving  
(100%CO<sub>2</sub>, 150A, 0.045")

**Recommended welding parameters and deposition rate**

Wire size (in.)	Wire feeding speed (in./min)	Current (A)	Voltage (V)	Deposition rate (lbs/hr)
0.035	205	90	23-25	2.5
	250	100	24-26	3.0
	280	110	25-27	3.3
	330	120	25-28	3.9
	375	130	27-29	4.5
	460	140	28-30	5.5
	550	150	29-31	6.6
0.045	210	130	24-26	5.0
	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
	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	32-35	13.5

Tables shown are approximate values that will vary depending on welding conditions(WESO, Cable length etc.).

Voltages shown are for 100%CO<sub>2</sub> shielding gas. For 75%Ar-25%CO<sub>2</sub> use two volts less than shown.

\*DC-Electrode positive \*\*Arc voltage is measured at wire feeder.



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.P65Warning.ca.gov](http://www.P65Warning.ca.gov).

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