



## DW-308L

**Classification: AWS A5.22 E308LT0-1  
AWS A5.22 E308LT0-4**

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

#### 1-1. Chemical Composition

[Unit: mass%]

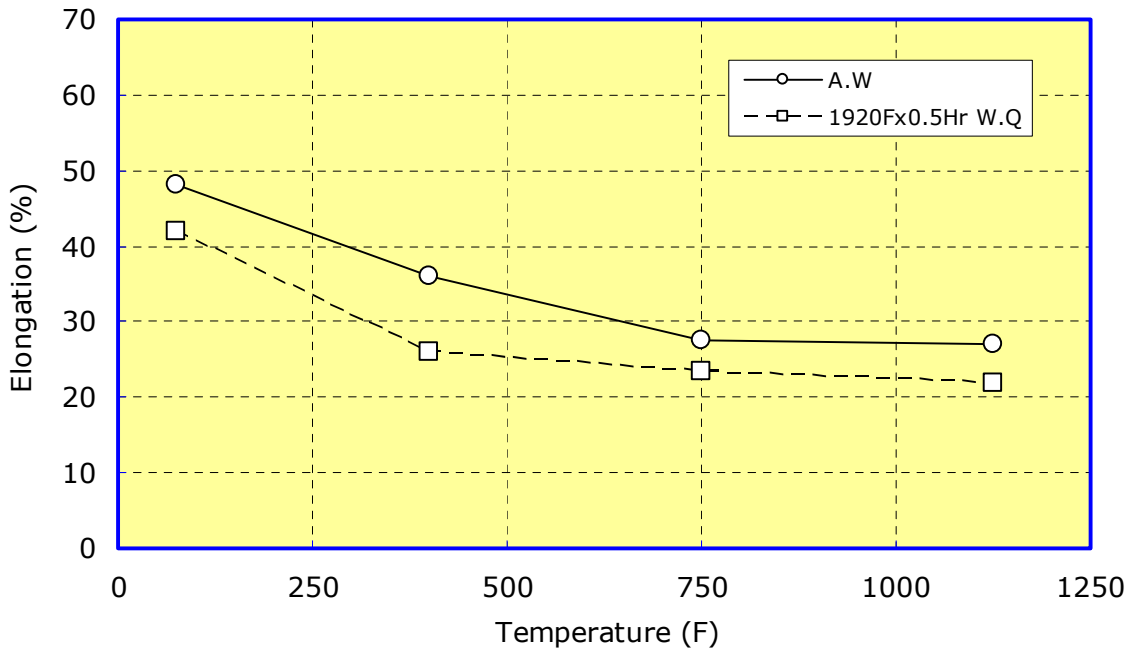
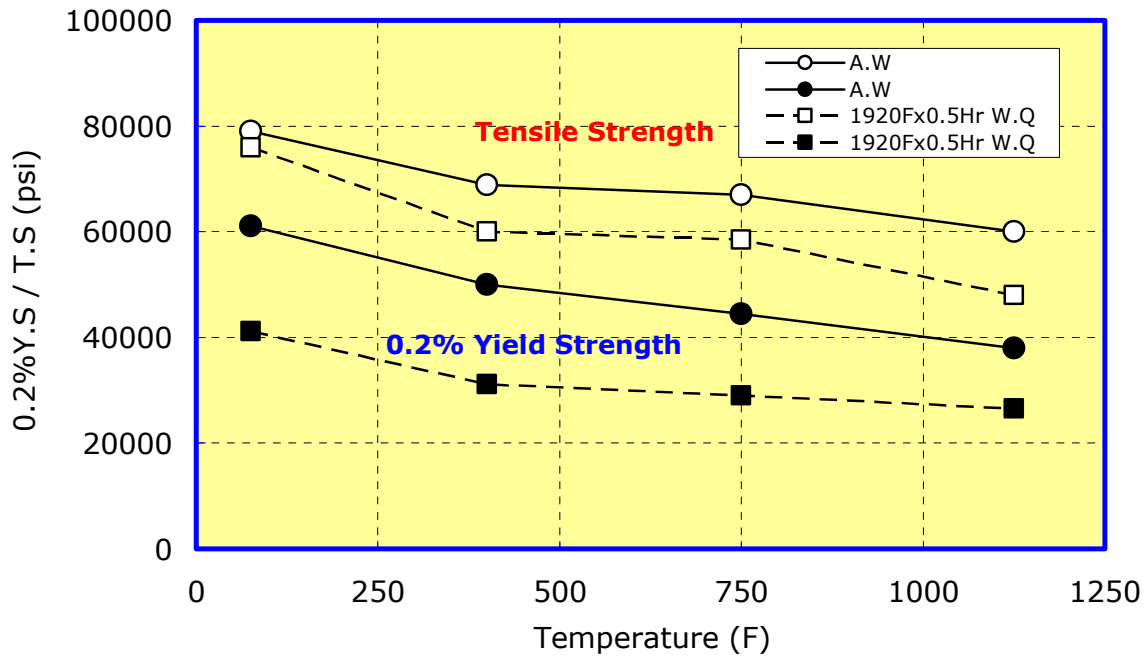
	C	Mn	Si	P	S	Ni	Cr	N
DW-308L	0.02	1.29	0.44	0.017	0.010	9.88	19.16	0.014
E308LT0-X	<0.04	0.5~2.5	<1.0	<0.04	<0.03	9.0~11.0	18.0~21.0	-----
	WRC-1992 (FN)		Shaeffler Diagram (%)		Delong Diagram (FN)			
DW-308L	9.2		7.8		10.2			
E308LT0-X	-----		-----		-----			

#### 1-2. Tensile Test

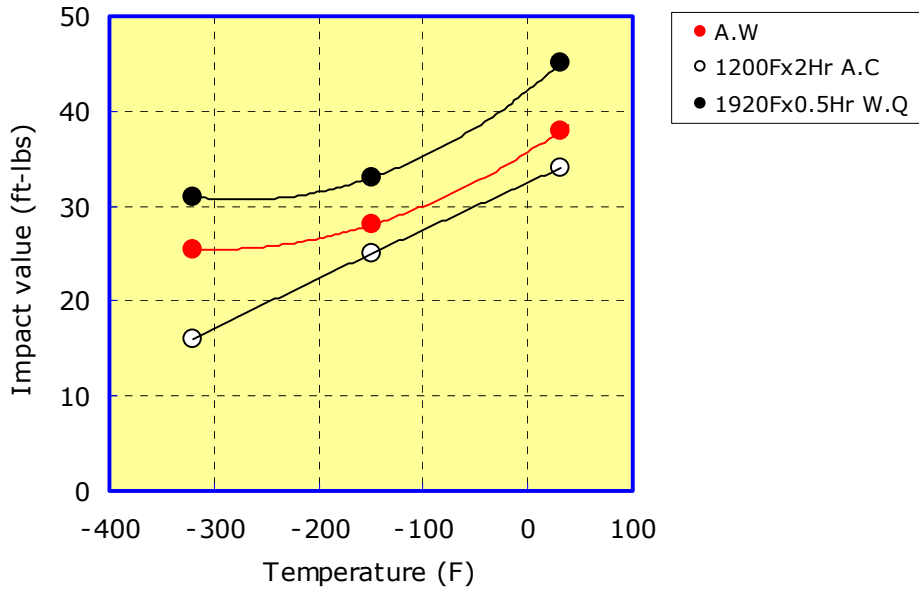
	0.2% Proof stress (psi)	Tensile strength (psi)	Elongation (%)	Reduction of Area (%)
DW-308L	61,132	78,898	42	47
E308LT0-X	---	>75,000	>35	---

Note) Test was completed in the as welded condition and at room temperature

**Kobelco Welding of America. Inc.**



## 1-3. Impact Test



## 1-4. Corrosion Test

PWHT	Test results (IPM)			
	1 <sup>st</sup>	2 <sup>nd</sup>	3 <sup>rd</sup>	Ave.
As Welded	0.00059	0.00065	0.00054	0.00059
1200° F - 2hr *	0.00081	0.00097	0.00101	0.00093
1920° F - 0.5hr **	0.00042	0.00045	0.00045	0.00044

\* Air cooled

\*\* Water quenched

Huey Test (65% Nitric Acid Test)

Welding Journal, Oct. 1951 "Corrosion Data of Welding Low Carbon Stainless Steel"

Excellent < 0.0009 IPM

Good < 0.0009 – 0.0021 IPM

Fair < 0.0021 – 0.0042 IPM

Poor > 0.0042 IPM

Copper sulfuric acid test

PWHT : 1200° F x 2Hr A.C

Bend test results : No defect

**Kobelco Welding of America, Inc.**



**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).