



Cromacore DW 308L

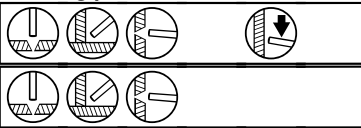
FCAW - Flux cored arc welding
Stainless Steel

Date: 2007-05-25
Revision: 12

Description:

Cromacore DW 308L is a rutile flux cored wire designed for welding the 18% Cr / 10% Ni type stainless steels. Suitable also for stabilised grades 347 and 321 if service temperature is below 400°C. The wire operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self-releasing slag. Cromacore DW 308L is used mainly for downhand and horizontal-vertical welding and is ideal for standing fillets.

Welding positions:



Welding current:

DC+

Deposition efficiency:

87%

Shielding gas:

M21, 80% Ar + 20% CO₂, 22-25 l/min
C1, 100% CO₂, 22-25 l/min

Stick-out:

15-25 mm

Ferrite content:

FN 6

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			18.0	9.0
Typical	0.03	0.6	1.8	0.020	0.010	19.3	10.0
Max	0.04	1.0	2.0	0.030	0.025	21.0	11.0

	Mo	Cu	V	Nb
Min				
Typical	0.1	0.09	0.1	0.08
Max	0.5	0.5	0.2	0.1

Mechanical properties

	Specified	Typical
Yield strength, R _{p0.2} %:		400 MPa
Tensile Strength, R _m :	≥ 520 MPa	570 MPa
Elongation, A ₅ :	≥ 35%	42%
Impact energy, CV:		-20 °C • 43 J

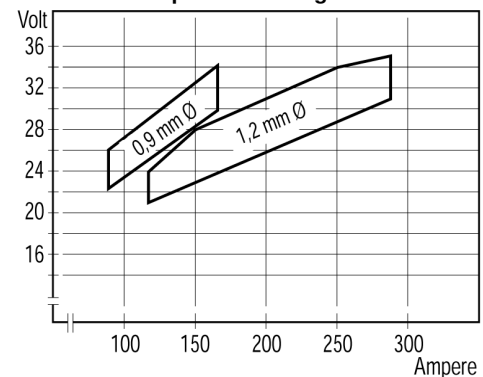
Classification:

AWS A5.22 E 308LT0-4/-1
ISO 17633-A T 19 9 L R M/C 3
Werkstoff no. 1.4316

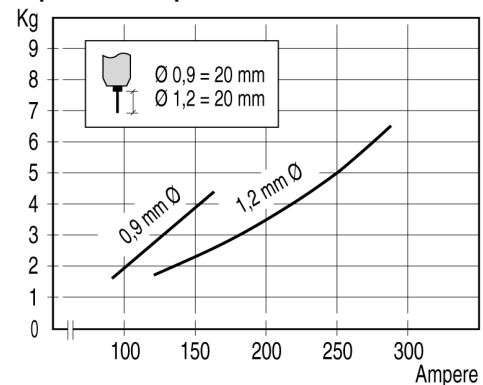
Approvals:

TÜV 07380.02
DNV 308L
GL 4550S
CE

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
0,9	95702009	12,5 kg D300
1,2	95701012	15 kg BS300
1,2	95701112	5 kg BS200

Note

Strip:
S ≤ 0.03%
P ≤ 0.04%
N ≤ 0.06%