

DW-G308L

80%Ar - 20%CO₂ / 100%CO₂
AWS A5.22 E308LT0-1/4

EN ISO 9606-1: FM5

EN ISO 4063: 136

DW-G309L

80%Ar - 20%CO₂ / 100%CO₂
AWS A5.22 E309LT0-1/4

EN ISO 9606-1: FM5

EN ISO 4063: 136

DW-G316L

80%Ar - 20%CO₂ / 100%CO₂
AWS A5.22 E316LT0-1/4

EN ISO 9606-1: FM5

EN ISO 4063: 136

Description and Application

Standard rutile flux cored wires in 1.2mm diameter are a popular choice for use at higher welding currents (>150A) due to their arc stability advantage over other welding processes. KOBELCO's DW-G series rutile flux cored 1.2mm wires are specially designed to provide excellent arc properties at a much lower welding current (80A to 220A range). Thanks to their unique design, they can also be used for many applications where 0.9mm rutile flux cored wires are usually applied. Very high welding speed (above 1.5m/min.) are achievable when using 100% CO₂ shielding gas.

KOBELCO's DW-G wires have the following features.

1. Excellent weldability

Stable arc and self releasing slag leaves a smooth and shiny bead surface with very little spatter.

2. High deposition rate

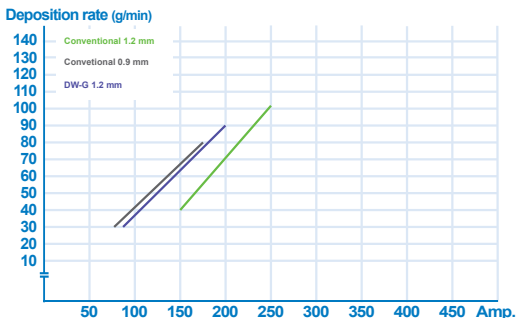
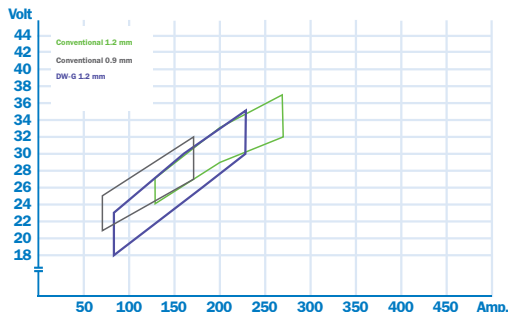
Its unique design assures a 15% higher deposition rate than regular 1.2mm rutile flux cored wire.

3. Failure-free arc ignition

Electrically conductive flux (slag) enables easy arc re-ignition for less trouble with automatic and stop start tack welding.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)

	C	Si	Mn	P	S	Ni	Cr	Mo	FS	FNW
DW-G308L	0.03	0.62	1.25	0.03	0.02	9.7	19.3	-	8.9	9.7
DW-G309L	0.03	0.68	1.21	0.03	0.02	12.5	24.1	-	13.2	20.4
DW-G316L	0.03	0.61	1.24	0.03	0.02	12.2	18.6	2.3	6.5	6.9

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)
DW-G308L	380	553	38
DW-G309L	420	564	35
DW-G316L	402	549	37

* The above values and parameters are for all weld metal produced using 100%CO₂ shielding gas

Applied base metal thickness (minimum)

Butt joint	Horizontal joint	Lap joint	Corner Joint	Vertical Downward Fillet
1.2 mm	1.6 mm	1.2 mm	1.6 mm	1.6 mm

Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-