



Cromacore DW 308LT

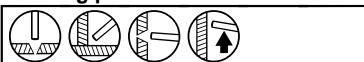
FCAW - Flux cored arc welding
Stainless Steel

Date:	1998-11-09
Revision:	3

Description:

Cromacore DW 308LT is a rutile flux cored wire designed for 304 austenitic stainless steel material used in cryogenic service. The tightly controlled chemical composition ensures a low ferrite but crack resistant weld material with good impact properties at -196°C . Cromacore DW 308LT operates with a very stable, spatter free arc producing a bright, smooth weld bead surface and self releasing slag. The wire is primarily intended for the horizontal and horizontal-vertical positions.

Welding positions:



Welding current:

DC +

Deposition efficiency:

87%

Shielding gas:

100% CO₂, 22-25 l/min.

Stick-out:

15-25 mm

Ferrite content:

FN 2

Chemical composition, wt. %

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			18.0	9.0
Typical	0.025	0.4	2.1	0.025	0.006	18.5	10.6
Max	0.04	1.0	2.5	0.04	0.03	21.0	11.0

	Mo	Cu	V	Nb	N
Min					
Typical	0.1	0.01	0.1	0.08	0.01
Max	0.5	0.5	0.2	0.1	

Mechanical properties

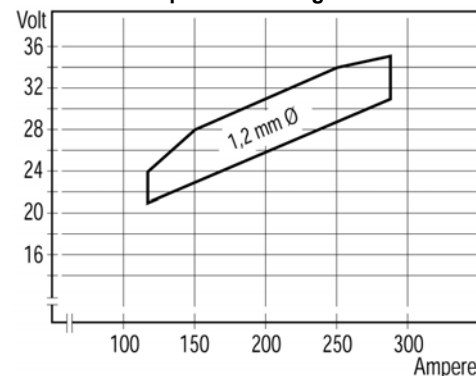
	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:		350 MPa
Tensile Strength, Rm:	≥ 520 MPa	530 MPa
Elongation, A5	≥ 35%	44%
Impact energy, CV:		-196°C • 37 J

Classification:

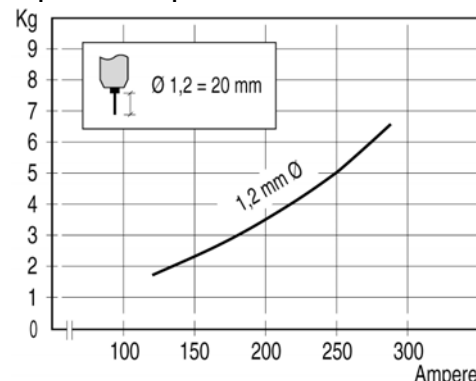
AWS A5.22 E308LT0-1
ISO 17633-A ~T 19 9L R C 3

Approvals:

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Delivery form
1,2	95705012	12,5 kg PSP

Note

For cryogenic service.
Ferrite content: Acc. to WRC-92.
Strip:
S ≤ 0.03%
P ≤ 0.04%
N ≤ 0.06%