



# Cromacore DW 308LP

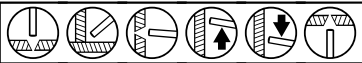
FCAW - Flux cored arc welding  
Stainless Steel

Date: 2007-05-25  
Revision: 12

## Description:

Cromacore DW 308LP is a rutile flux cored wire intended for welding the 18% Cr / 10% Ni type stainless steels. The wire has been specially designed for fully positional welding at high welding currents. Suitable also for stabilised grades 347 and 321 if service temperature is below 400°C. Cromacore DW 308LP operates with a very stable, spatter free arc and produces a bright, smooth weld bead surface and self-releasing slag. Ideal for high productivity welding in the vertical position.

## Welding positions:



## Welding current:

DC+

## Deposition efficiency:

87%

## Shielding gas:

M21, 80% Ar + 20% CO<sub>2</sub>, 22-25 l/min

C1, 100% CO<sub>2</sub>, 22-25 l/min

## Stick-out:

15-25 mm

## Ferrite content:

FN 9

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0.5			18.0	9.0
Typical	0.03	0.7	1.5	0.020	0.010	19.6	9.9
Max	0.04	1.0	2.0	0.030	0.025	21.0	11.0

	Mo	Cu	V	Nb
Min				
Typical	0.1	0.05	0.1	0.08
Max	0.5	0.5	0.2	0.1

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Rp0.2%:		400 MPa
Tensile Strength, Rm:	≥ 520 MPa	590 MPa
Elongation, A5	≥ 35%	41%
Impact energy, CV:		-20°C • 40 J

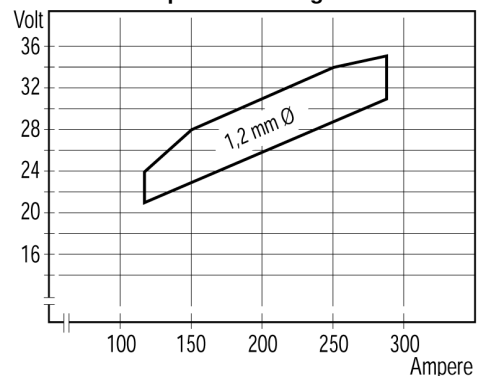
## Classification:

AWS A5.22 E 308LT1-4/-1  
ISO 17633-A T 19 9 L P M/C 1

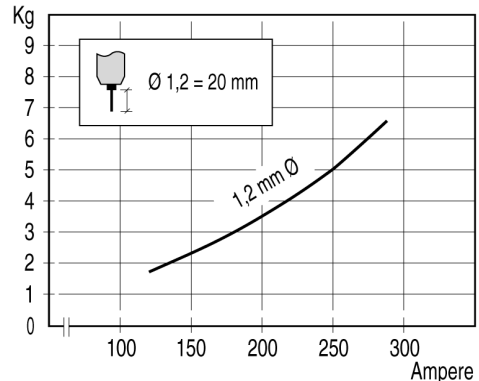
## Approvals:

TUV 09140.00  
GL 4550S  
LR 304L S  
CE

## Recommended parameter range:



## Deposition rate per hour:



Diam.mm	Product code	Spool weight
1,2	95771012	15 kg BS300
1,2	95771112	5 kg BS200

## Note

Strip:  
S ≤ 0.03%  
P ≤ 0.04%  
N ≤ 0.06%