


**KOBELCO FCW Data Sheet 4**
**DW-308L**
**Classification : AWS A5.22 E308LT0-1  
 AWS A5.22 E308LT0-4**
**All-Weld-Metal (100% CO4****4-1. Chemical Composition****Unit : wt%**

	C	Mn	Si	P	S	Ni	Cr	N
DW-308L	0.024	1.29	0.44	0.017	0.010	9.88	19.16	0.014
E308LTX-X	10.04	0.5/2.5	≤1.0	≤0.04	≤0.03	9.0/11.0	18.0/21.0	---

**4-2. Ferrite Content**

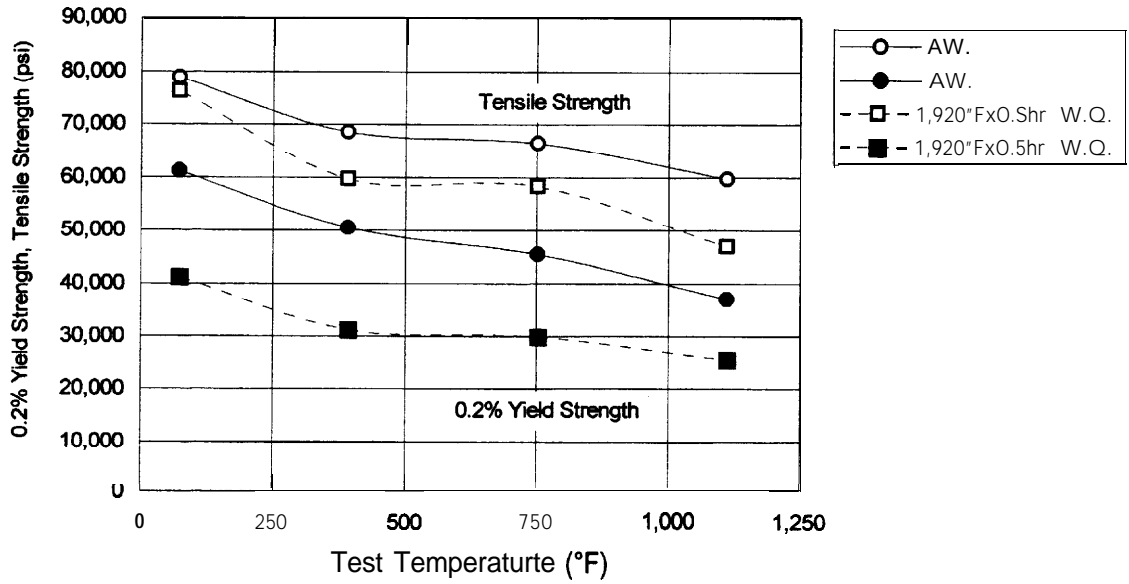
	Shaeffler Diagram (%)	Delong Diagram (FN)	1992-WRC Diagram (FN)
As Welded	7.8	10.2	9.2

**4-3. Tensile Test**

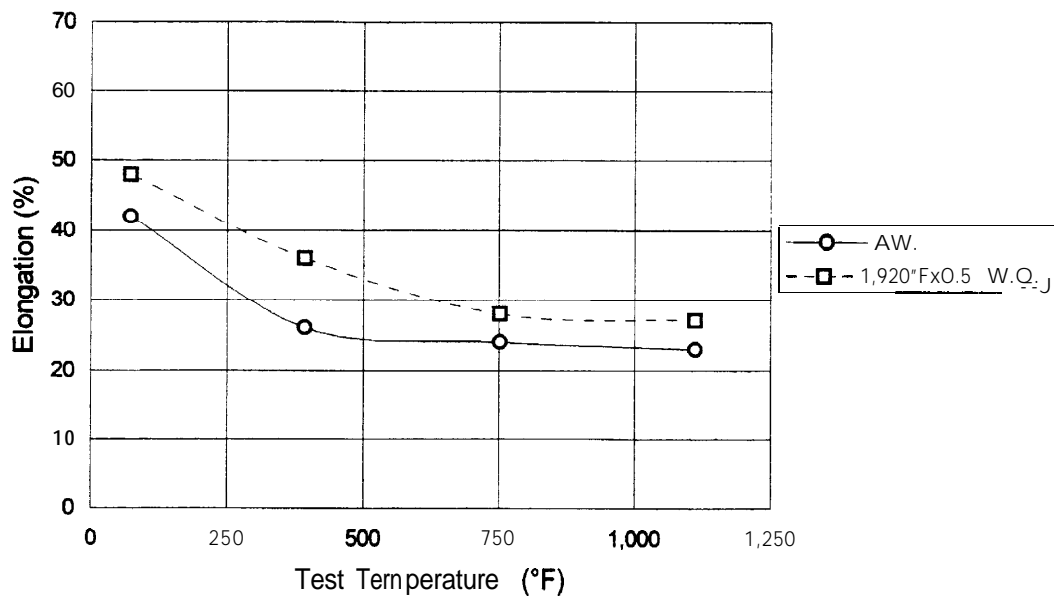
	0.2% Yield Strength (psi)	Tensile Strength (psi)	Elongation (%)	Reduction of Area (%)
DW-308L	61,132	78,898	42	47
E308LTX-X	---	275,000	≥35	---

Note: Test was completed in the as-welded condition at room temperature.

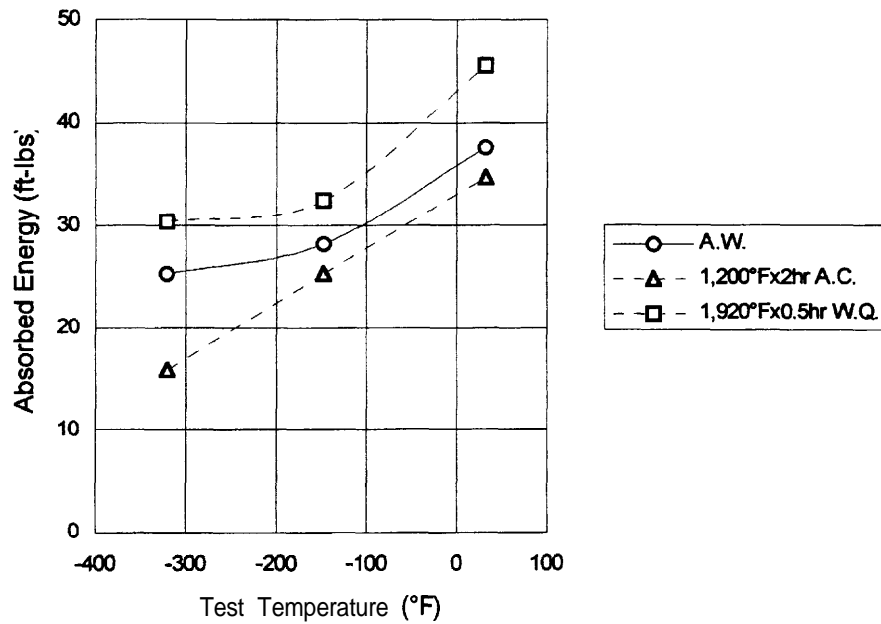
## 4-4. Tensile Strength and 0.2% Yield Strength



## 4-5. Elongation



## 4-6. Impact Test



## 4-7. Corrosion Test

### Huey Test

	Test Results (IPM)			
	1st	2nd	3rd	Avg.
As Welded	0.00059	0.00065	0.00054	0.00059
1,200°F x 2hr *	0.00081	0.00097	0.00101	0.00093
1,920°F x 0.5hr **	0.00042	0.00045	0.00045	0.00044

Note : \* Air Cooled, \*\* Water Quenched

Huey Test (65% Nitric Acid Test)

Welding Journal, October 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 Sulfate Sulfuric Acid Test

PWHT: 1,200°F x 2hr A.C.

Bend Test Results : No Defect