

Trade designation	ASME AWS Class.	Type of cored flux	SG	Pol.	Features	WP	Chemical		composition of all-weld metal (%)							Mechanical properties of all-weld metal					
							C	Si	Mn	P	S	Ni	Cr	Others	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	SG		
DW-316LT	A5.22 E316L T1-1/4	Rutile	CO ₂ Ar- CO ₂	DC- EP	•Suitable for 18%Cr-12%Ni-2%Mo stainless steel for low temperature service	F HF H VU OH	Ex	0.027	0.41	1.20	0.021	0.008	12.39	17.62	2.21	Ex	405	537	44	-196°C: 40	CO ₂
							Gt	≤0.040	≤1.00	0.50- 2.50	≤0.040	≤0.030	11.00- 14.00	17.00- 20.00	Mo: 2.00- 3.00	Gt	-	≥490	≥35	-196°C ≥27	
DW-317L	A5.22 E317L T0-1/4	Rutile	CO ₂ Ar- CO ₂	DC- EP	•Suitable for 18%Cr-12%Ni-2%Mo-N and 19%Cr-13%Ni-3%Mo stainless steel	F HF	Ex	0.025	0.59	1.10	0.020	0.010	13.01	19.81	Mo: 3.35	Ex	380	590	37	0°C: 43	CO ₂
							Gt	≤0.040	≤1.00	0.50- 2.50	≤0.040	≤0.030	12.00- 14.00	18.00- 21.00	Mo: 3.00- 4.00	Gt	-	≥520	≥20	-	
DW-347	A5.22 E347 T0-1/4	Rutile	CO ₂ Ar- CO ₂	DC- EP	•Suitable for 18%Cr-8%Ni-Nb and 18%Cr-8%Ni-Ti stainless steel	F HF	Ex	0.026	0.41	1.48	0.018	0.008	10.46	18.66	Nb: 0.58	Ex	390	550	43	0°C: 49	CO ₂
							Gt	≤0.08	≤1.00	0.50- 2.50	≤0.040	≤0.030	9.00- 11.00	18.00- 21.00	Nb: 8xC- 1.00	Gt	-	≥520	≥30	-	

Note: Welding tests are as per AWS. Ex: Example, Gt: Guaranty

■ Approvals

DW-316LT	AB, LR, BV, KR
DW-317L	CWB
DW-347	CWB

■ Diameter (mm)

DW-316LT	1.2
DW-317L	1.2, 1.6
DW-347	1.2, 1.6