

LP Series

PREMIARC™
DW-308LP / E308LT1-1/4

PREMIARC™
DW-309LP / E309LT1-1/4

PREMIARC™
DW-316LP / E316LT1-1/4



Outstanding Features

- Excellent performance in vertical upward position with either 75%Ar-25%CO₂ gas mixture or 100%CO₂.
- Flatter bead shape is guaranteed with easy torch operation in vertical position as well as horizontal position.
- LP series provide high productivity with less-fume and less-spatter which could minimize extra work time on post welding cleanup.

- ❖ Conform to AWS, ASME and CWB classification
- ❖ 0.035, 0.045" and 1/16" with 28Lbs spool are available

Typical chemistry of weld metal (0.045" Dia. 100%CO₂)

Alloy	C	Si	Mn	Cr	Ni	Mo	FN
DW-308LP	0.02	0.69	1.55	19.47	10.03	-	10.2
DW-309LP	0.02	0.45	1.34	23.33	12.55	-	19.9
DW-316LP	0.02	0.46	1.39	19.00	12.64	2.23	9.3

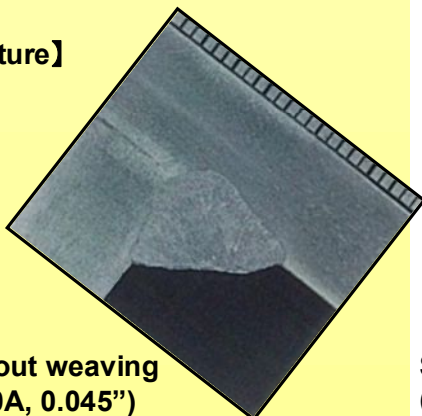
FN=Ferrite Number by WRC Diagram (1992)

Typical mechanical property of weld metal (0.045" Dia. 100%CO₂)

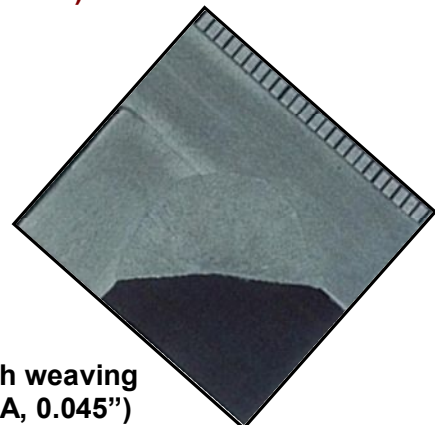
Alloy	0.2%P.S (psi)	T.S (psi)	Elongation (%)
DW-308LP	60,010	78,200	40
DW-309LP	59,990	78,875	41
DW-316LP	60,675	81,786	36

Test method: AWS A5.22, welding parameter: 200A-28V (0.045")

【Sectional structure】



Straight-up without weaving
(100%CO₂, 150A, 0.045")



Straight-up with weaving
(100%CO₂, 150A, 0.045")



PREMIARC™ DW-308LP

AWS A5.22 E308LT1-1, -4

PREMIARC™ DW-309LP

AWS A5.22 E309LT1-1, -4

PREMIARC™ DW-316LP

AWS A5.22 E316LT1-1, -4

Recommended welding parameters and deposition rate

Wire size (in.)	Wire feeding speed (in./min)	Current (A)	Voltage (V)	Deposition rate (lbs/hr)
0.035	205	90	23-25	2.5
	250	100	24-26	3.0
	280	110	25-27	3.3
	330	120	25-28	3.9
	375	130	27-29	4.5
	460	140	28-30	5.5
	550	150	29-31	6.6
0.045	210	130	24-26	5.0
	275	155	25-27	6.0
	330	175	26-28	6.8
	380	190	27-29	8.0
	440	210	28-30	9.5
	540	230	28-31	10.6
	610	250	30-33	12.0
1/16	160	190	28-30	6.5
	195	210	29-31	8.0
	220	230	29-31	8.5
	250	260	31-33	9.5
	280	270	31-33	11.0
	320	300	31-34	12.0
	350	320	32-35	13.5

Tables shown are approximate values that will vary depending on welding conditions(WESO, Cable length etc.).

Voltages shown are for 100%CO₂ shielding gas. For 75%Ar-25%CO₂ use two volts less than shown.

*DC-Electrode positive **Arc voltage is measured at wire feeder.

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