

**MIDALLOY MASTERCOR™ E308T1-1/4 / E308HT1-1/4 AP FLUX-CORED WIRE**

**CLASSIFICATION**

- AWS 5.22 Class E308T1-1, E308HT1-1, E308T1-4, and E308HT1-4 / ASME SFA 5.22 Class E308T1-1, E308HT1-1, E308T1-4, and E308HT1-4 flux-cored wire.
- UNS# W30831 A# 8 F# 6

**DESCRIPTION**

- MIDALLOY Mastercor™ E308T1-1/4 and E308HT1-1/4 are gas shielded flux-cored wires designed for all-position welding and can be used with 75% Argon / 25% CO<sub>2</sub> or 100% CO<sub>2</sub> shielding gas.

**APPLICATIONS**

- MIDALLOY Mastercor™ E308T1-1/4 and E308HT1-1/4 is used widely in welding various components for the chemical, paper, textile, food processing, and pharmaceutical industries.
- MIDALLOY Mastercor™ E308T1-1/4 and E308HT1-1/4 can be used for joining stainless steel alloys such as types AISI 301, 302, 304, 305, and 308.
- Because of the higher Carbon content (.04 - .08%) MIDALLOY Mastercor™ E308HT1-1/4 provides higher tensile strength and creep strength at elevated temperatures. This product is used primarily for welding type 304H base material.

**TYPICAL CHEMISTRY (%)**

C	Mn	Si	Cr	Ni	Mo	P	S	Cu	N
0.06	1.2	.70	19.5	10.0	.15	.03	.02	.02	.05

Controlled Ferrite WRC 92: 4-10 FN

**TYPICAL MECHANICAL PROPERTIES\***

TENSILE STRENGTH	87,000 PSI
YIELD STRENGTH	62,000 PSI
ELONGATION IN 2"	35%

\*Note: Mechanical properties shown using 100% CO<sub>2</sub> shielding gas

**OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO<sub>2</sub> shielding gas)**

DIAMETER	AMPERAGE	VOLTAGE	WFS (IPM)	STICK/OUT
.045"	160-200	26-28	300-425	5/8" - 3/4"
1/16"	215-250	27-28	190-240	3/4" - 1"

Note: Lower by 2 volts when using 75AR / 25CO<sub>2</sub>

**STANDARD PACKAGING**

- 33 lb. spool

8/3/11

*The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.*

Office and Corporate Warehouse  
 630 Axminister Drive  
 St. Louis, MO 63026 • 636-349-6000 • 800-776-3300  
 Fax 636-349-2240

