

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% CO₂ or 100% CO₂ 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% CO₂ shielding gas

OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO₂ 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 / 25CO₂

STANDARD PACKAGING

- 33 lb. spool

8/3/11

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