

MIDALLOY MASTERCOR™ E308HT0-1/4 F & H FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E308HT0-1 and E308HT0-4 / ASME SFA 5.22 Class E308HT0-1 and E308HT0-4 flux cored wire.
- UNS# W30831 A# 8 F# 6

DESCRIPTION

- MIDALLOY Mastercor™ E308HT0-1/4 is a gas shielded flux-cored wire designed for flat and horizontal welding and can be used with 75% Argon 25% CO₂ or 100% CO₂ shielding gas.

APPLICATIONS

- The composition of Mastercor™ E308HT0-1/4 is the same as Class E308T0-1/4 except the carbon content is in the high end of the range .04% to .08%. This range provides higher tensile strength and creep strength at elevated temperatures. This product is used primarily for welding type 304H base metal.

TYPICAL CHEMISTRY (%)

C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu
0.06	1.10	.58	18.90	9.90	.10	.015	.015	.05	.10

Controlled Ferrite WRC 92: 2-10 FN

TYPICAL MECHANICAL PROPERTIES*

TENSILE STRENGTH	87,000 PSI
YIELD STRENGTH	65,500 PSI
ELONGATION IN 2"	42%

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"	170-200	27-29	335-440	5/8" / 3/4"
1/16"	210-270	28-31	235-345	3/4" / 1"

Note: Lower volts by 2 volts when using 75AR/25CO₂

STANDARD PACKAGING

- 33 lb. spool

12/29/08

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

