

## MIDALLOY MASTERCOR™ E308LT0-1/4 F & H FLUX-CORED WIRE

### CLASSIFICATION

- AWS 5.22 Class E308LT0-1 and E308LT0-4 / ASME SFA 5.22 Class E308LT0-1 and E308LT0-4 flux cored wire.
- UNS# W30835 A# 8 F# 6

### DESCRIPTION

- MIDALLOY Mastercor™ E308LT0-1/4 is a gas shielded flux-cored wire designed for flat and horizontal welding and can be used with 75% Argon 25% CO<sub>2</sub> or 100% CO<sub>2</sub> shielding gas.

### APPLICATIONS

- MIDALLOY Mastercor™ E308LT0-1/4 is used for welding stainless steel grades 301, 302, 304L, 308, and 308L for various applications for the chemical, paper, pharmaceutical, textile, food and other industries.

### TYPICAL CHEMISTRY (%)

C	Mn	Si	Cr	Ni	Mo	P	S	N
0.03	1.22	.63	20.10	10.40	.20	.015	.015	.05

Controlled Ferrite WRC 92: 8-12 FN

### TYPICAL MECHANICAL PROPERTIES\*

TENSILE STRENGTH	82,300 PSI
YIELD STRENGTH	58,700 PSI
ELONGATION IN 2"	38%

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"	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/25CO<sub>2</sub>

### STANDARD PACKAGING

- 33 lb. spool

12/29/08

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