

MIDALLOY MASTERCOR™ E308LT1-1/4 AP FLUX-CORED WIRE

CLASSIFICATION

- AWS 5.22 Class E308LT1-1 and E308LT1-4 / ASME SFA 5.22 Class E308LT1-1 and E308LT1-4 flux cored wire.
- UNS# W30835 A# 8 F# 6

DESCRIPTION

- MIDALLOY Mastercor™ E308LT1-1/4 is a gas shielded flux-cored wire designed for all position welding and can be used with 75% Argon 25% CO₂ or 100% CO₂ shielding gas.

APPLICATIONS

- MIDALLOY Mastercor™ E308LT1-1/4 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	Cu	N
0.03	1.22	.87	20.30	10.70	.20	.015	.015	.20	.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% 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 volts by 2 volts when using 75AR/25CO₂

STANDARD PACKAGING

- 33 lb. spool

12/29/08

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