

**MIDALLOY MASTERCOR™ E308LT1-1/4 AP CRYO LF (LOW FERRITE)  
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 AP Cryo (low ferrite) is an all position flux cored wire used to weld 304L and 304 stainless cryogenic applications.
- MIDALLOY Mastercor™ E308LT1-1/4 AP Cryo has excellent slag removal and runs with a spatter free globular transfer.
- Carbon content value is controlled to be less than 0.03% and Ferrite <5 FN.

**APPLICATIONS**

Base material plates such as 201, 304, and 304L. This product has excellent toughness and lateral expansion for services down to 320°F. In some cases MIDALLOY E308LT1-1/4 AP Cryo can be used when low ferrite is required.

**TYPICAL CHEMISTRY (Ferrite Number WRC 1992 – 3)**

C	Mn	Si	Cr	Ni	Mo	P	S	Cu	N
0.03	1.23	0.79	18.0	10.5	.23	0.027	0.006	0.28	.05

**TYPICAL MECHANICAL PROPERTIES\***

<b>TENSILE STRENGTH</b>	83,700 PSI
<b>YIELD STRENGTH</b>	57,000 PSI
<b>ELONGATION IN 2"</b>	45%
<b>IMPACTS @ -320 °F</b>	28 ft-lb with 22 mils lateral expansion

\*Note: Mechanical properties shown using 75% Argon / 25% CO<sub>2</sub> shielding gas. Strength levels are slightly lower when using 100% CO<sub>2</sub>

**OPTIMUM TYPICAL WELDING PARAMETERS (using 100% CO<sub>2</sub> shielding gas or 75 AR/25 CO<sub>2</sub>)**

DIAMETER	AMPERAGE	VOLTAGE	WFS (IPM)
.035"	100-170	23-26	265-525
.045"	120-220	24-28	250-430
1/16"	180-250	25-30	150-250

\*Note: Optimum for .045" – 200 amps, 26.5 volts, and 430 IPM (for CO<sub>2</sub> gas use 2 more volts)

**PRODUCT AVAILABILITY**

.035", .045", and 1/16" Diameters

**STANDARD PACKAGING**

- 33 lb. spool

5/21/10

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