



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

308LT Flux Cored Wire

U.S. ALLOY CO.
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7010-G Reames Rd.
Charlotte, NC 28216
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ALLOY DESCRIPTION AND APPLICATION;

E308LT1-1/4 is a flux cored wire for single or multi-pass welds on stainless steels which is noted for its low spatter generation, excellent bead shape and appearance and ease of slag removal. It has very good deposit efficiency when used for flat and fillet welds of medium and heavy thickness plates and has been designed to be used with 100% CO₂ or 75-80% Argon + balance CO₂ mixed shield gas. E308LT1-1/4 provides weld deposits with optimum ferrite content in its austenitic structure resulting in low susceptibility to cracking. The extra low carbon content of E308LT1-1/4 provides excellent resistance to intergranular corrosion and stress corrosion cracking. E308LT1-1/4 is used extensively in the fabrication of stainless steel structures, pressure vessels, tanks used in dairy, pulp and paper, textile dyeing, refinery and chemical equipment. The extra low carbon content reduces carbide precipitation. E308LT1-1/4 can be used to weld stainless steels of similar alloy composition including AISI 304L, 308L, 321, 347, and CF-3, CF-8 or whenever welds are required to meet structural and intergranular corrosion resistance requirements. E308LT0-1/4 may be more fluid giving a flat to concave bead profile.

TYPICAL WELDING PROCEDURES; DCEP

| Wire Diameter | Wire Speed (ipm) | Amps | Volts | Electrical Stickout | CO ₂ (cfh) |
|---------------|------------------|---------|-------|---------------------|-----------------------|
| 0.045" | 215-550 | 140-380 | 23-35 | 1/2-1" | 35-50 |
| 1/16" | 125-615 | 150-410 | 24-36 | 5/8-1.25 " | 35-50 |

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. 2 volts for mixed gas

CHEMISTRY (%) for Undiluted WELD METAL & PROPERTIES (75/25)

| | AWS Requirements) | Typical | | (AWS Requirements) | Typical |
|------------------------|-------------------|------------------|------------|--------------------|---------|
| Carbon | 0.04 | 0.03 | Molybdenum | 0.75 | 0.18 |
| Manganese | 0.5-2.5 | 1.87 | Phosphorus | 0.04 | 0.014 |
| Silicon | 1.00 | 0.75 | Sulfur | 0.03 | 0.016 |
| Chromium | 18.0-21.0 | 19.50 | Nickel | 9.0-11.0 | 10.30 |
| | | AWS Requirements | | As Welded | |
| Tensile Strength (psi) | | 75,000 min. | | 88,600 | |
| Yield Strength (psi) | | N/A | | 67,750 | |
| Elongation | | 35% min. | | 38% | |

Iron balance and all single values are maximum percentages unless noted

AVAILABLE SIZES: TSF 308LT

Other sizes available – please inquire

SPECIFICATIONS; ANSI/AWS A5.22 E308LT0-1/-4 or E308LT1-1/-4

ASME SFA 5.22 E308LT0-1/-4 or E308LT1-1/-4

ASME F-6, A-8

T0 = flat and horizontal; T1 = all position; -1 is for 100% CO₂; -4 = 75-80 Ar /CO₂

EAST COAST

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GULF COAST

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WEST COAST

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