



# 308L Stainless Steel Seamless Flux Cored

U.S. ALLOY CO.  
dba Washington Alloy  
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Quality Management System  
in accordance with  
**ISO 9001**  
Cert # 05-R0925



## ALLOY DESCRIPTION AND APPLICATION;

E308LT1-1/-4 is a flux cored seamless wire for single or multi-pass welds on stainless steels. Noted for its seamless sheath giving it many outstanding benefits such as; Superior moisture absorption resistance, delivers flawless low diffusible hydrogen levels throughout the entire spool, much lower friction wear on liners and tips, extremely stable and pin point arc 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 while. It has been designed to be used with 100% CO<sub>2</sub> or 75-80% Argon + balance CO<sub>2</sub> mixed shield gas. 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. E308LT-1 can be used to weld stainless steels of similar alloy composition including AISI 304L, 308L, 321 and 347 and 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 GMAW WELDING PROCEDURES; DCEP 75Ar/25Co<sub>2</sub>

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electric stick out	75Ar/25Co <sub>2</sub> (cfh)
0.035	325-725	125-250	21-30	1/2 -1"	35-45
0.045	225-700	150-300	25-33	1/2 -3/4"	40-50
1/16"	125-380	170-305	23-29	3/4 -1"	40-50

*Based on Flat & Horizontal – add 2 volts with 100% CO<sub>2</sub>*

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

## E308LT1-1/-4 CHEMISTRY (%) for Undiluted WELD METAL & PROPERTIES

(AWS Requirements) *Typical			(AWS Requirements) *Typical		
Carbon	0.04	0.03	Molybdenum	0.75	0.12
Manganese	0.5-2.5	1.29	Phosphorus	0.04	0.028
Silicon	1.00	0.53	Sulfur	0.03	0.003
Chromium	18.0-21.0	19.99	Nickel	9.0-11.0	9.92
Copper	0.75	0.14	FERRITE%		9.9
		AWS Requirements		As Welded	
Tensile Strength (psi)		75,000 min.		84,400	
Yield Strength (psi)		N/A		71,350	
Elongation		30% min.		40%	

Iron balance and all single values are maximum percentages unless noted;; \*Based on 100% CO<sub>2</sub>  
All single values on composition are maximum percentages & Total other elements 0.50

**AVAILABLE SIZES:** TCC SF 308 = Spools of .030, .035, .045, 1/16"

**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% CO<sub>2</sub>; -4 = 75-80 Ar /CO<sub>2</sub>**

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