



E308LT1-1/4



DESCRIPTION: E308LT1-1/4 is a flux cored wire for Flat, H-Fillet, V-up, down position welding for use with welding grade CO₂ or Ar-CO₂ (75%Ar-25%CO₂) shielding gas. It provides excellent usability with stable arc, less spattering, good bead appearance. For mechanized welding of H-Fillet this wire is an excellent choice, as it meets the requirement of superior wire feeding properties combined with high deposition efficiency. E308LT1-1/4 is suitable for Welding of low carbon 18%Cr-8%Ni Austenitic stainless steel(SUS 301, 304(L), 308(L))

APPROVAL: CWB(A5.22 E308LT1-1/4) & AWS A5.22 E308LT1-1/4

CHEMICAL COMPOSITION

CARBON	.028
SILICON	.60
MANGANESE	1.61
PHOSPHORUS	.012
SULFUR	.010
NICKEL	10.10
CHROMIUM	19.42

MEHCANICAL PROPERTIES

Tensile Strength	
85,000 PSI	590 MPA
Yield Strength	
76,000 PSI	527 MPA
Elongation	
	42%

DEPOSITION WELDING

WELDING PROCEDURE

Wire diameter : 1.2mm
 Amperage : 180 — 220A
 Voltage : 30-32V
 Current & polarity : DCEP
 Shielding gas : CO₂100%, 20ℓ /min
 Wire stick-out : 20 — 25mm
 Interpass temp : 150°C max.
 Welding position : Flat
 Welding speed : 300 — 400mm/min
 Preheat temp. : N/A
 Root treatment : No

BUTT WELDING

WELDING PROCEDURE

Wire diameter : 1.2mm
 Amperage : 180 — 220A
 Voltage : 30-32V
 Current & polarity : DCEP
 Shielding gas : CO₂100%, 20ℓ /min Wire
 stick-out : 20 — 25mm
 Interpass temp. : 150°C max.
 Welding position : Flat
 Welding speed : 300- 400mm/min
 Preheat temp.. : N/A
 Root treatment : No