



E308L

Specifications / Certifications:
AWS A5.22 E308LT0-1/4

Features

- Excellent weldability
- Increased creep resistance at elevated temperature
- Lower crack susceptibility

Applications

- Designed for MAG welding of low carbon stainless steels

Technical Specifications

- Use 100% CO₂ gas or Ar+20-25% CO₂ gas.
- The optimum flow of CO₂ for shielding is 20-25 l/min.
- Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 6.56 ft/sec (2m/sec) and more.
- Keep the distance between tip & base metal at 0.59-0.98 in (15-25 mm).
- For multi-layer welding, keep preheat and inter-pass temperature below 302°F (150°C)

Typical Chemical Composition:

Chemical	C	Mn	Si	P	S	Cr	Ni	Mo
AWS	0.04 max	0.5-2.5	1.0 max	0.04 max	0.03 max	18-21	9-11	0.5 max
100% CO₂	0.02	1.25	0.50	0.022	0.004	20.10	10.43	0.01
Ar+20% CO₂	0.03	1.33	0.55	0.021	0.004	20.21	10.31	0.01

Typical Mechanical Properties:

	Tensile Strength (psi)	Elongation	Impact Value (J)
AWS	75,419 min psi	30% min	
100% CO₂	82,961 psi	43%	84
Ar+20% CO₂	87,747 psi	40%	86

Recommended GMAW Weld Parameters:

Flat	
Diameter	Amps
0.045"	180-220A
0.062"	200-280A
Horizontal Fillet	
Diameter	Amps
0.045"	180-220A
0.062"	200-280A

Welding positions



1G



2F

Diameters & Packages

Diameter		Lbs	Pkg
0.023"	23/1000	2	Spool
		10	Spool
0.025"	1/4"	2	Box
		10	Box
		33	Box
0.030"	1/32"	1	Box
		2	Box
		10	Box
		25	Spool
0.035"	7/200"	33	Spool
		1	Box
		2	Box
		10	Box
		25	Spool
0.045"	3/64"	33	Spool
		250	Box
		2	Box
		5	Box
		10	Box
		25	Box
		30	Spool
		33	Spool
0.052"	13/250"	250	Spool
		500	Drum
0.062"	1/16"	25	Spool
		1	Box
		10	Box
		15	Box
		33	Spool
		60	Coil
		330	Reel
0.078"	5/64"	500	Drum
		10	Box
0.093"	3/32"	60	Coil
		5	Box
		10	Box
		15	Box
		50	Box
		55	Coil
		60	Coil
		330	Reel
		750	Drum
0.125"	1/8"	5	Box
		10	Box
		15	Box
		55	Coil
		60	Coil
0.156"	5/32"	10	Box
		60	Coil
		330	Reel
0.187"	3/16"	10	Box
		60	Coil