



# 308LT1-1

**Specifications / Certifications:**  
AWS A5.22 E308LT1-1/4

## 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% CO<sub>2</sub> gas or Ar+20-25% CO<sub>2</sub> gas.
- The optimum flow of CO<sub>2</sub> 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
<b>AWS</b>	0.04 max	0.5-2.5	1.0 max	0.04 max	0.03 max	18-21	9-11	0.5 max
<b>100% CO<sub>2</sub></b>	0.02	1.28	0.7	0.022	0.004	19.9	9.91	0.01
<b>Ar+20% CO<sub>2</sub></b>	0.03	1.40	0.75	0.020	0.004	19.94	9.83	0.01

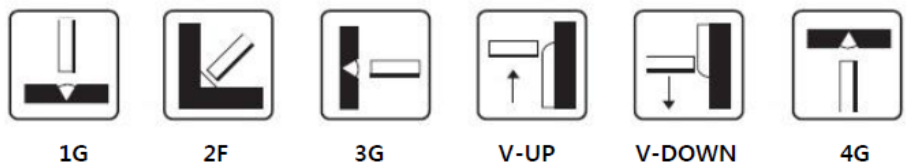
### Typical Mechanical Properties:

	Tensile Strength (psi)	Elongation	Impact Value (J)
<b>AWS</b>	75,419 min psi	30% min	
<b>100% CO<sub>2</sub></b>	85,862 psi	43%	55
<b>Ar+20% CO<sub>2</sub></b>	90,503 psi	40%	59

### 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
Vertical Up	
Diameter	Amps
0.045"	120-160A
0.062"	160-220A

### Welding positions



**Diameters & Packages**

Diameter		Lbs	Pkg
0.023"	23/1000"	2	Spool
0.030"	1/32"	10	Spool
0.035"	7/200"	2	Spool
		10	Spool
		25	Spool
		33	Spool
0.045"	3/64"	2	Spool
		5	Spool
		10	Spool
		25	Spool
		33	Spool
0.062"	1/16"	1	Box
		10	Box
		33	Spool
0.093"	3/32"	10	Box
0.125"	1/8"	5	Box
		10	Box
		55	Coil
0.156"	5/32"	10	Box
0.187"	3/16"	10	Box