Oxford® ALLOYS, Inc.
Supplier of Welding Alloys

Stainless Steel Flux Cored Wire

Oxford Alloy® 308HT-1

SPECIFICATIONS
AWS 5.22
ASME SFA 5.22

CLASSIFICATIONS
AWS E308HT1-1/T1-4
UNS W30831

DESCRIPTION / APPLICATION

Oxford Alloy E308HT1-1/T1-4 is used for welding types 304H and 347H stainless when high temperature service is required. Minimum carbon content allowed is 0.04%. Oxford Alloy E308HT1-1/T1-4 was developed for out-of-position welding. This flux cored wire will deposit out-of-position welds at substantially higher welding currents than other stainless steel flux cored wires, resulting in a higher deposition rate. The slag is self-peeling and minimizes cleanup. Oxford Alloy E308HT1-1/T1-4 was formulated for use with 75% Argon/25% CO^2 shielding gas; however, straight CO^2 may also be used. The 75/25 mixture will produce a smooth arc with virtually no spatter and slightly higher yield and tensile strengths than CO^2. The mechanical properties and deposit analysis will meet AWS 5.22 specifications with either gas.

AWS Chemical Composition

C	Mn	Si	Cr	Ni	Mo	P
0.04-0.08	0.5-2.5	1.0 max	18.0-21.0	9.0-11.0	0.5 max	0.04 max
S	**Cu**					
0.03 max	0.5 max					

TYPICAL MECHANICAL PROPERTIES

Tensile strength:	88,450 psi	610 MPa
Yield strength:	66,700 psi	460 MPa
Elongation:	40%	

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.