



*Supplier of Welding Alloys*

## Stainless Steel Flux Cored Wire

### Oxford Alloy® 308LT-1

#### **SPECIFICATIONS**

AWS 5.22  
ASME SFA 5.22

#### **CLASSIFICATIONS**

AWS E308LT1-1/T1-4  
UNS W30835

#### **DESCRIPTION / APPLICATION**

Oxford Alloy E308LT1-1/T1-4 is a flux cored wire used for welding types 301, 302, 304, 304L, 308, and 308L. This flux cored wire may also be used for welding types 321 and 347 if service temperature does not exceed 500°F (260°C). Maximum carbon content allowed is 0.04%. The carbon content is a 0.04% maximum. This low carbon content minimizes carbide precipitation. Ferrite values will lower as impact toughness increases. Oxford Alloy E308LT1-1/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 E308LT1-1/T1-4 was formulated for use with 75% Argon/25% CO<sup>2</sup> shielding gas; however, straight CO<sup>2</sup> 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<sup>2</sup>. 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 max	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: 84,100 psi 580 MPa

Yield strength: 66,700 psi 460 MPa

Elongation: 38%

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

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