

FLUX CORED

Oxford Alloy® 308HT1-1/4

AWS E308HT1-1/T1-4 • Stainless Steel

Key Features

- ❖ Designed for all-position welding
- ❖ Carbon content is controlled between .04 -08 % and Provides superior weld performance and enhanced operator appeal.
- ❖ Hermetically sealed packaging to ensure freshness.

Conformances

AWS/ASME SFA 5.22
E308HT1-1/T1-4
UNS W30831

Chemical Composition - As required per AWS 5.22

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	0.75 max	0.04 max
S	Cu					
0.03 max	0.75 max					

Mechanical Properties - As required by AWS 5.22

	Tensile Strength MPa (ksi)	Yield Strength MPa (ksi)	Elongation %	Charpy V-Notch J (ft-lbf) @ 20 °C (68°F)
AWS Requirements	550 (80) min	Not Specified	30 min	Not Specified
Typical Results - As welded	610 (89)	460 (67)	40	51 (38)

Recommended Shielding Gas

100% CO₂
75% Argon / 25% CO₂



Typical Welding Parameters

Diameter	.045 (1.14mm)				1/16" (1.6mm)			
	130	165	190	220	170	210	250	300
Amperage	25	26	28	30	25	27	28	29
Voltage	227	341	445	567	154	193	243	321
Wire Feed speed (in/min)	4.25	6.14	8.08		5.34	6.89	8.57	11.43
Deposition rate (lbs/hr)	84.0	83.0	84.0	84.0	83.0	82.5	83.0	83.0
% Efficiency								

The ESO (Electrical Stick Out) is 1/2" - 1". DCEP (electrode positive) is specified. When using 75% Argon / 25% CO₂ mixture, decrease voltage by as much as 2 volts.

Diameters & Packaging

Oxford Alloys USA			Oxford Alloys Asia Pacific		
Diameter (in)	Spool Dimension (in)	Spool Weight (lbs)	Diameter (mm)	Spool Dimension (mm)	Spool Weight (kgs)
.045	12	33 lb spool	1.2	300	15 kg spool
1/16	12	33 lb spool	1.6	300	15 kg spool

Actual test results may vary. Refer test result disclaimer on page 160.