

Inweld 308LT1-AP

Chemical Composition of AWS A5.22 E308LT1-1/4(AP)

C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu	Fe
0.04	18.0- 21.0	9.0- 11.0	0.5	0.5- 2.5	1.0	0.04	0.03	---	0.75	Balance

Single values are maximum unless otherwise specified.

Description and Applications

The composition of this alloy differs from 308LT0-1 solely due to the flux. The flux provided in this flux-cored alloy allows for all-position welding.

The composition of this weld metal is the same as 308TX-X, except for carbon content. By specifying low carbon in this alloy, it is possible to obtain resistance to intergranular corrosion due to carbide precipitation without the use of stabilizers such as columbium (niobium) or titanium. This low-carbon alloy, however, is not as strong at elevated temperature as the E308 and columbium (niobium)-stabilized alloys.

Procedure

Typical Weld Metal Properties

	<u>AWS Spec</u>
Average As-Welded Hardness:	
Tensile Strength:	75,000
Yield Strength:	
Elongation:	35%

Recommended Parameters

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
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