

308LT-3 FLUX CORED WELDING WIRE

AWS A5.22 E308LT0-3 | ASME SFA 5.22 E308LT0-3 (T0 = flat and horizontal) **-3 = no gas needed**



Description and Application

E308LT-3 is a flux cored self shielded wire for single or multi-pass welds on stainless steels which is noted for its low spatter generation, excellent bead shape and appearance and ease of slag removal. It has very good deposit efficiency when used for flat and fillet welds . E308LT-3 provides weld deposits with optimum ferrite content in its austenitic structure resulting in low susceptibility to cracking. The extra low carbon content of E308LT-3 provides excellent resistance to intergranular corrosion and stress corrosion cracking. E308LT-3 is used extensively in the fabrication of stainless steel structures, pressure vessels, tanks used in dairy, pulp and paper, textile dyeing, refinery and chemical equipment. The extra low carbon content reduces carbide precipitation. E308LT-3 can be used to weld stainless steels of similar alloy composition including AISI 304L, 308L, 321, 347, and CF-3, CF-8 or whenever welds are required to meet structural and intergranular corrosion resistance requirements.

Available Sizes

diameter	2 lb	11 lb	33 lb
0.035	X	X	
0.045	X	X	X
1/16"			
3/32"			

Other sizes available – please inquire



Typical Weld Metal Chemistry (%)

	AWS Spec	308LT-3
Carbon	0.04	0.017
Chromium	19.5-22.0	20.74
Nickel	9.0-11.0	10.28
Molybdenum	0.75	0.26
Manganese	0.5-2.5	1.71
Silicon	1.0	0.47
Phosphorus	0.04	0.034
Sulfur	0.03	0.004
Copper	0.75	0.37

Tensile Strength (psi)
Yield Strength (psi)
Elongation 2"

AWS Spec

75,000
na
35% min

308LT-3

87,850
62,200
41%

AWS spec single values are maximum

Typical FCAW Welding Procedures; DCEP (FLAT)

Wire diameter	Wire speed (ipm)	Amps	Volts	Electrical stickout
0.035	310-575	90-185	24-29	3/8-3/4"
0.045	260-510	120-230	24-30	1/2-1"
1/16"	180-390	165-270	26-31	1/2-1"

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