



Stainless Steel Flux Cored Wire



Code & Specification

ASME SFA/AWS A5.22 E308LT1-1 (CO₂) E308LT1-4 (Argon +20-25% CO₂)

Description

BLUME[®] E308LT1-1/4 is a stainless steel flux cored wire with all positional capabilities. Vacuum sealed in aluminised plastic packs. Formulated for CO₂ or Argon +20-25% CO₂ shielding gases. High deposition rate welding of stainless steel. Welds well in all positions. Excellent welder appeal. Provides a low spatter hence requiring less clean-up. Good weld soundness and extended shelf-life. Fast freezing and self detaching slag. Provides spray-like arc transfer and high moisture resistance.

Applications

Used for joining common austenitic stainless steel such as Types 301, 302, 304, 304L, 321, CF-3 and CF-8.

Mechanical Properties

	As-welded (Argon +20-25% CO ₂)	As-welded (CO ₂)
Yield Strength, MPa	420	390
Tensile Strength, MPa	550	580
Elongation, %(L=4d)	35	43

Undiluted Weld Metal Analysis (wt%)

		Using CO ₂		
C	Mn	Si	Cr	Ni
≤ 0.02	1.40 - 2.00	0.60 - 0.70	19.0 - 20.0	10.0 - 11.0
P	S			
≤ 0.03	≤ 0.03			

Suggested Welding Parameters (DC+)

Diameter	Flat		Vertical-up		Overhead	
	Volts	Amps	Volts	Amps	Volts	Amps
1.2mm (.045")	23 - 28	150 - 250	22 - 27	120 - 180	22 - 27	140 - 180

Packaging

15 kgs (33 lbs) [Net Weight] Plastic spools with OD = 270mm (11")

Approvals



Blumenotics Pvt. Limited

An ISO 9001:2015 Company

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