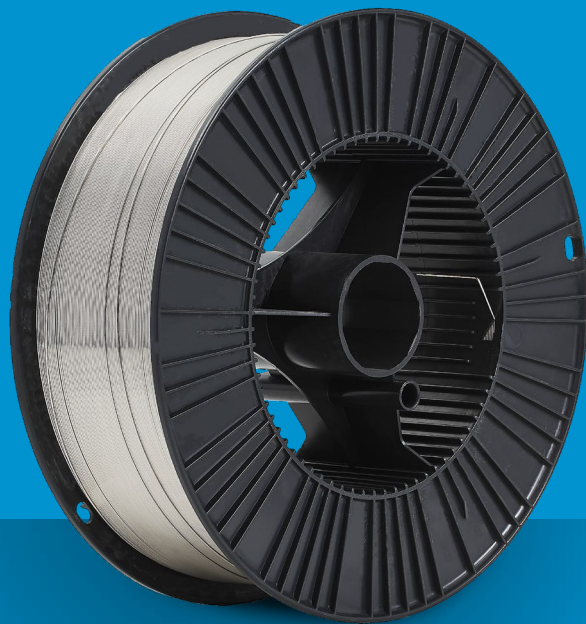


VERTI-COR 308LT

PRODUCT DATA SHEET



VERTI-COR STAINLESS STEEL FLUX CORED WIRES; 308LT- ALL POSITIONAL CAPABILITIES



DC+



VERTI-COR 308LT

- Vacuum Sealed in Aluminised Plastic Packs.
- Formulated for CO₂ or Argon + 18-25% CO₂ Shielding gases.
- High Deposition Rate Welding of Stainless Steels.

CLASSIFICATIONS:

AWS/ASME-SFA A5.22:

E308LT1-1(CO₂) /
E308LT1-4 (Ar + 18-25%CO₂).

RECOMMENDED SHIELDING GAS:

AS 4882: ISO 14175 / AWS A5.32:

SG-C C1

SG-AC-18, or SG-AC-20 M21

Welding grade CO₂ or Ar+CO₂ (18-25%)

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

	USING CO ₂ :	ARGON + 18-25% CO ₂ :
0.2% Proof Stress	390 MPa	400 MPa
Tensile Strength	550 MPa	580 MPa
Elongation	43%	40%

TYPICAL ALL WELD METAL ANALYSIS:

USING WELDING GRADE CO₂:

C:	0.03%
Mn:	1.30%
Si:	0.70%
Cr:	19.5%
Ni:	9.9%
P:	0.020%
S:	0.003%

DESCRIPTION AND APPLICATIONS:

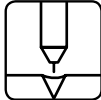

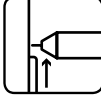
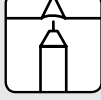
Verti-Cor 308LT is a gas shielded stainless steel flux cored wire developed for positional welding applications on 19Cr/9Ni stainless steel grades including AISI types 301, 302, 304 and 304L etc.

Verti-Cor 308LT is a versatile, stainless steel flux cored wire recommended for all positional welding applications. The rutile type flux core gives smooth arc transfer characteristics and very low spatter levels with both CO₂ and Argon + 18-25% CO₂ shielding gases. The fast freezing slag gives excellent weld pool control resulting in smooth mitre to slightly convex fillet welds in the flat, horizontal-vertical, vertical-up and overhead welding positions.

Actual weld metal mechanical properties achieved with Verti-Cor wires are influenced by many factors including, base metal analysis, welding parameters / heat input used, shielding gas selection, number of weld passes and run placement etc. Please consult your nearest CIGWELD branch for welding procedure recommendations.

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation and DC electrode positive and welding grade CO₂ shielding gas with a flow rate of 15-20 litres/min.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING POSITION	
1.2	150-250	23-28	15-20		Flat
1.2	150-200	23-28	15-20		HV Fillet
1.2	120-180	22-27	15-20		Vertical up
1.2	140-180	22-27	15-20		Overhead

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.

COMPARABLE CIGWELD PRODUCTS:

Autocraft 308LSi GMAW Wire	AWS A5.9: ER308LSi
Comweld 308L GAS/TIG rod	AWS A5.9: ER308L
Satinchrome 308L-17 Electrode	AWS A5.4: E308L-17

PACKAGING DATA:

WIRE DIAMETER (MM)	TYPE	PACK WEIGHT	PACK PART NO.
1.2	Spool	15kg	722889



P/N: 722889

