STOODY
A Thermadyne Company

Brilliant® 308L T-1 AP
Gas Shielded Flux Cored Wire

AWS CLASSIFICATION A5.22-95 E308LT1-X

DESCRIPTION

Stoody® AP stainless steel wires are designed for welding in all positions with either 100% CO_2 (X=1) or Argon / CO_2 (X=4) gas mixtures. These wires exhibit a spray like arc transfer, easy slag removal and can be welded within a wide range of parameters.

Stoody® 308LT-1 AP wires can be used to join AISI 301, 302, 304 commonly used in the chemical industry and food processing applications.

TYPICAL DEPOSIT CHEMISTRY (wt%)

GAS	75 Ar / 25 CO_2	100% CO_2
Carbon	0.032	0.030
Manganese	0.8	0.7
Silicon	0.8	0.7
Chromium	20.1	19.6
Nickel	10.2	10.2
Ferrite Number	8	7

NOTES:
- Chemical composition values are typical and were developed using in accordance with AWS A5.22-95 procedures. Actual test results may vary depending on welding parameters and base metal composition.
- Ferrite values were determined with the Magna Gage.
- Ferrite values may vary depending on specific operating parameters.

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.035” (0.9mm)	25# WB, Can Pack	11894000
.045” (1.2mm)	33# WB, Can Pack	11910700
1/16” (1.6mm)	33# WB, Can Pack	11909500

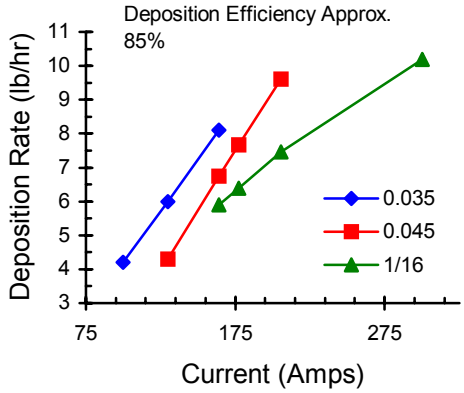
OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS (DCEP)

.035” (0.9mm)					
Amps		100[1]	120[1]	150[1]	170[1]
Volts		25	26	27	27
WFS	in/min	275	374	480	600
	(m/min)	*(6.9)*	*(9.5)*	*(12.2)*	*(15.3)*
.045” (1.2mm)					
Amps		130[1]	165[1]	190[1]	220[2]
Volts		24	26	26	27
WFS	in/min	227	315	445	565
	(m/min)	*(5.8)*	*(8.7)*	*(11.3)*	*(14.4)*
1/16” (1.6mm)					
Amps		170[1]	210[1]	250[2]	300[2]
Volts		25	26	27	28
WFS	in/min	155	195	245	320
	(m/min)	*(3.9)*	*(4.9)*	*(6.2)*	*(8.2)*

NOTES:
- 3/8” - 1/2” (10 - 12mm) electrical stick out.
- [1] Flat and vertical welding
- [2] Flat welding only

TYPICAL DEPOSIT CHARACTERISTICS

GAS	75 Ar / 25 CO_2	100% CO_2
Tensile Strength, Ksi (MPa)	88 (610)	86 (600)
Elongation (%)	39	41
Yield Strength, Ksi (MPa)	63 (435)	60 (415)



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PDS-SS-W-001
Revision 4
02/25/02

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