



CORE-BRIGHT 308L

Welds types 301, 302, 304, 304L, 321, and 347 stainless steels and austenitic steels. Used extensively for welding chemical plant equipment.

Classifications	AWS A5.22 : E308LT0-3
Approvals	CERTIFIED BY C.W.B. - AWS A5.22 AWS A5.22 E308LT0-3 ASME SFA 5.22

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	430 MPa (62 ksi)	620 MPa (90 ksi)	40 %

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate	TTW Dist.	Deposition Efficiency %
1.2 mm (.045 in.)	110 A	26 V	762 cm/min (300 in./min)	2.6 kg/h (5.8 lb/h)	19 mm (3/4 in.)	86 %
1.2 mm (.045 in.)	150 A	27 V	1016 cm/min (400 in./min)	3.67 kg/h (8.1 lb/h)	19 mm (3/4 in.)	86 %
1.2 mm (.045 in.)	180 A	27 V	1270 cm/min (500 in./min)	4.45 kg/h (9.8 lb/h)	19 mm (3/4 in.)	87 %
1.6 mm (1/16 in.)	150 A	27 V	508 cm/min (200 in./min)	3.08 kg/h (6.8 lb/h)	19 mm (3/4 in.)	87 %
1.6 mm (1/16 in.)	210 A	28 V	762 cm/min (300 in./min)	4.67 kg/h (10.3 lb/h)	19 mm (3/4 in.)	87 %
1.6 mm (1/16 in.)	270 A	29 V	1016 cm/min (400 in./min)	6.12 kg/h (13.5 lb/h)	19 mm (3/4 in.)	85 %
2.4 mm (3/32 in.)	250 A	26 V	284 cm/min (112 in./min)	3.8 kg/h (8.4 lb/h)	25.4 mm (1 in.)	85 %
2.4 mm (3/32 in.)	250 A	26 V	338 cm/min (133 in./min)	4.5 kg/h (10.0 lb/h)	38 mm (1-1/2 in.)	89 %
2.4 mm (3/32 in.)	300 A	28 V	345 cm/min (136 in./min)	4.6 kg/h (10.2 lb/h)	25.4 mm (1 in.)	85 %
2.4 mm (3/32 in.)	300 A	28 V	402 cm/min (178 in./min)	6.1 kg/h (13.5 lb/h)	38 mm (1-1/2 in.)	89 %
2.4 mm (3/32 in.)	350 A	29 V	467 cm/min (184 in./min)	6.3 kg/h (13.9 lb/h)	25.4 mm (1 in.)	88 %
2.4 mm (3/32 in.)	350 A	29 V	577 cm/min (227 in./min)	7.8 kg/h (17.1 lb/h)	38 mm (1-1/2 in.)	87 %
2.4 mm (3/32 in.)	400 A	30 V	561 cm/min (221 in./min)	7.3 kg/h (16.2 lb/h)	25.4 mm (1 in.)	85 %
2.4 mm (3/32 in.)	400 A	30 V	767 cm/min (302 in./min)	10.3 kg/h (22.7 lb/h)	38 mm (1-1/2 in.)	87 %
2.4 mm (3/32 in.)	450 A	30 V	693 cm/min (273 in./min)	9.3 kg/h (20.6 lb/h)	25.4 mm (1 in.)	85 %
2.4 mm (3/32 in.)	450 A	30 V	871 cm/min (343 in./min)	11.7 kg/h (25.9 lb/h)	38 mm (1-1/2 in.)	87 %
2.0 mm (5/64 in.)	210 A	24 V	348 cm/min (137 in./min)	3.2 kg/h (7.1 lb/h)	19 mm (3/4 in.)	86 %
2.0 mm (5/64 in.)	250 A	26 V	460 cm/min (181 in./min)	4.3 kg/h (9.5 lb/h)	19 mm (3/4 in.)	87 %
2.0 mm (5/64 in.)	300 A	27 V	599 cm/min (236 in./min)	5.4 kg/h (12.0 lb/h)	19 mm (3/4 in.)	85 %