

Characteristics and Applications:

HOBART 308LT1-1 is designed for 100% CO₂ gas shielding and all-position welding. It exhibits excellent slag detachability. And almost spatter-free operating features can be used for joint of austenitic steels such as Types 304, 304L, 321, CF-8, and CF-3. It also provides better inter-granular corrosion resistance due to a low carbon weld deposit.

Notes on Usage:

1. Before welding, oil, rusty, and moisture should be cleaned off the base material that should have the proper protection from the wind in welding site.
2. Use 99.8% purity or higher CO₂ shielding gas.
3. Keep the product dry, while it is stored or delivered.

Typical Chemical Composition of Weld Metal (wt%):

	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
AWS	≤ 0.04	0.5-2.4	≤ 1.0	≤ 0.04	≤ 0.03	18.0-21.0	9.0-11.0	≤ 0.75	≤ 0.75
EN ISO	≤ 0.04	0.5-2.5	≤ 1.2	≤ 0.030	≤ 0.025	18.0-21.0	9.0-11.0	≤ 0.3	≤ 0.5
Typical value	0.026	1.40	0.50	0.023	0.008	19.50	9.80	0.82	0.12

Typical Mechanical Properties of Weld Metal

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≥ 520(75)	≥ 30
EN ISO	≥ 320(46)	≥ 510(74)	≥ 30
Typical value	460(67)	565(82)	40

Welding Position



Sizes and Recommended Operating Range (DC<+>)

Stick Out:15-20(mm), Flow Rate:20-25(l/min)

Diameter (mm)	1.2	1.6
Position		
F, HF	130A-220A / 24V-33V	200A-300A / 27V-35V
H	140A-180A / 25V-29V	200A-300A / 27V-35V
V-UP	130A-160A / 24V-28V	160A-200A / 24V-27V
OH	150A-180A / 25V-29V	--