

Arcaloy MC308L

Arcaloy MC308L is a composite metal cored stainless steel wire which has a stainless steel sheath. Arcaloy MC308L is used for welding types 301, 302, 304, and 304L. This may be used for welding types 321 and 347 if service temperatures do not exceed 500°F(260°C). Its higher deposition rate and less penetration compared to solid wire makes it very suitable for making butt, fillet and lap welds on gauge material. Higher speeds are also possible compared to solid wire. The low spatter and slag-free welds make this electrode ideal for automatic and robotic welding. The pushing technique can be used to further minimize the penetration and oxide film formed on the surface of the weld. Typical applications include automobile catalytic converters, manifolds, mufflers, exhaust systems. For welding in the spray mode of metal transfer, the shielding gas should be argon with 1 or 2% oxygen or carbon dioxide. Pulse welding can also be used to further minimize penetration in thin gauge steels. This metal cored wire can also be used in submerged arc welding in combination with 10.93 Flux.

Specifications	
Classifications	SFA/AWS A5.22 : EC308L
Industry	Mobile Equipment Pipeline Ship/Barge Building Industrial and General Fabrication Automotive Process

Welding Current	DC+
Alloy Type	MC308L

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	Cu	Ferrite FN
0.03	1.50	0.55	10	20	0.10	0.10	10

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (0.045 in.)	144-441 A	16-30 V	4.06-14.73 m/min (160-580 in./min)	1.9-7.2 kg/h (4.2-15. lbs/h)