WILKINSON STAR

WELD STAR®

DUAL CORE 308L-T1

Stainless CORED/FCAW

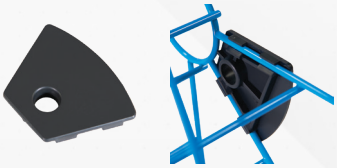
Standards

EN/ISO-Standard - 17633-A
EN/ISO-Classification - T 19 9 L P M21 1 / T 19 9 L P C1 1

AWS-Standard - A5.22
AWS-Classification - E308LT1-4 - E308LT1-1

Features and Applications

- Rutile flux cored stainless steel wire for gas-shielded arc welding.
- 19% chromium - 9% nickel - low carbon deposit.
- Specifically designed for out-of-position welding.
- Attractive bead appearance, very good penetration, excellent X-ray soundness.
- Maximum productivity for completion of vertical welds.
- Precision layer wound for superior wire feeding characteristics.
- Suitable for welding stainless steels with an alloy content between 16 to 21% Cr and 8 to 13% Ni, stabilised or not.
- **Test Certificates can be found online @wilkinsonstar247.com**



Optional
Plastic Alignment Hole Clip
Order Code: BS300-CLIP

Approvals

CE, UKCA

Typical Base Materials

302, 304, 304L, 304LN, 305, 308, 321, 347, S30200, S30400, S30403, S20453, J92701, S30800, S32100, S34700, X12 CrNi 18 8, X5 CrNi 18-10, X2 CrNi 19-11, X2 CrNiN 18-10, GX10 CrNi 18-8, X4 CrNi 18-12*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - C1, M21

Polarity

DC (+)

Welding Parameters

Ø mm	1.20
Current (A)	130-270
Voltage (V)	22-35

Mechanical Properties (Typical) - M21

Tensile Strength (N/mm^2)	Yield Strength (N/mm^2)	Elongation (%)	Impact Strength (J)	Test Temperature
620	460	40	35	-196ºC

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Mn %	Si %	Cr %	Ni %	S %	P %
0.03	1.40	0.70	20.0	10.5	0.008	0.020

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010201808	1.20	15	BS300 PLW	72