

# Dual Core 308L-T1

Stainless CORED/FCAW

## Standards

EN/ISO-Standard - 17633-A

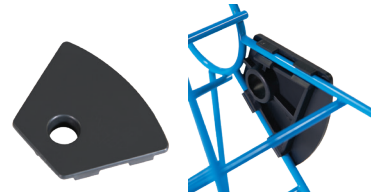
EN/ISO-Classification - T 19 9 L P M21 1 / T 19 9 L P C1 1

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

## Typical Base Materials

AISI	UNS	EN Symbol
302	S30200	X12 CrNi 18 8
304	S30400	X5 CrNi 18-10
304L	S30403	X2 CrNi 19-11
304LN	S20453	X2 CrNiN 18-10
305	J92701	GX10 CrNi 18-8
308	S30800	X4 CrNi 18-12
321	S32100	X6 CrNiTi 18-10
347	S34700	X6 CrNiNb 18-10

\* 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 (+)

## 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

## Welding Parameters

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

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
620	460	40	35	-196°C

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

**Liability:** Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

