

Dual Core 309L-T1

Stainless CORED/FCAW

Standards

EN/ISO-Standard - 17633-A

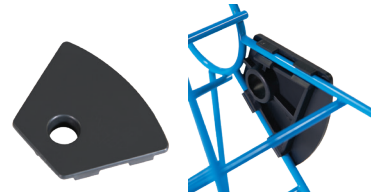
EN/ISO-Classification - T 23 12 L P M21 1 / T 23 12 L P C1 1

AWS-Standard - A5.22

AWS-Classification - E309LT1-4 - E309LT1-1

Features and Applications

- Rutile flux cored stainless steel wire for gas-shielded arc welding.
- 24% chromium - 13% nickel - low carbon deposit.
- Specifically designed for out-of-position welding.
- Attractive bead appearance, automatic slag release, very good penetration and high productivity.
- Excellent X-ray soundness.
- Maximum productivity for completion of vertical welds.
- Ideal for welding stainless steels of similar composition or ferritic stainless steels.
- Precision layer wound for superior wire feeding characteristics.
- Application include joining stainless steels to mild and low-alloyed steels. Also rebuilding and buffering before cladding or hardfacing.
- **Test Certificates can be found online @wilkinsonstar247.com**



Optional Plastic Alignment Hole Clip
Order Code: BS300-CLIP

Typical Base Materials

Dissimilar welds between stainless steel types 304, 304L, 316, 316L, 318, 316Ti, 321, 410 or ferritic stainless steel types 1.4713, 1.4724, 1.4742, 3Cr12, to non or low alloyed CMn steels, for service temperatures up to 400°C.

* 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
580	460	35	40	-60°C

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	23.5	13.0	0.008	0.020

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010201810	1.20	15	BS300 PLW	72

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.



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