

# Dual Core 316L-T1

Stainless CORED/FCAW

## Standards

EN/ISO-Standard - 17633-A

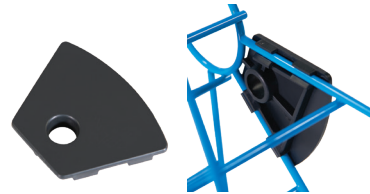
EN/ISO-Classification - T 19 12 3 LP M21 1 / T 19 12 3 LP C1 1

AWS-Standard - A5.22

AWS-Classification - E316LT1-4 - E316LT1-1

## Features and Applications

- Rutile flux cored stainless steel wire for gas-shielded arc welding.
- 19% chromium - 12% nickel - 3% molybdenum - low carbon deposit.
- Attractive bead appearance, automatic slag release, very good penetration and high productivity.
- Excellent X-ray soundness.
- Specifically designed for out-of-position welding.
- 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, 6 to 13% Ni and up to 3% Mo, stabilised and un-stabilised types.
- **Test Certificates can be found online @wilkinsonstar247.com**



Optional Plastic Alignment Hole Clip  
Order Code: BS300-CLIP

## Typical Base Materials

| AISI  | UNS    | EN Symbol           |
|-------|--------|---------------------|
| 316   | S31600 | X5 CrNiMo 17-12-2   |
| 316L  | S31603 | X2 CrNiMo 17-13-2   |
| 316LN | S31653 | X2 CrNiMoN 17-12-2  |
| 316Ti | S31635 | X6 CrNiMoTi 17-12-2 |
| 318   | S31640 | X10CrNiMoNb 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 <sup>2</sup> ) | Yield Strength (N/mm <sup>2</sup> ) | Elongation (%) | Impact Strength (J) | Test Temperature |
|---------------------------------------|-------------------------------------|----------------|---------------------|------------------|
| 600                                   | 490                                 | 35             | 50                  | -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 % | Mo % | S %   | P %   |
|------|------|------|------|------|------|-------|-------|
| 0.03 | 1.40 | 0.80 | 19.0 | 12.0 | 2.90 | 0.008 | 0.020 |

## Packaging Data

| Part No.   | Diameter Ø (mm) | Package Weight (Kg) | Package Type | Pallet Quantity |
|------------|-----------------|---------------------|--------------|-----------------|
| 3010201812 | 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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