



DUAL CORE 316L-T1

Stainless CORED/FCAW



Standards

EN/ISO-Standard - 17633-A

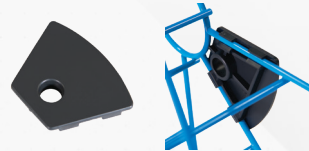
EN/ISO-Classification - T 19 12 3 L P M21 1 / T 19 12 3 L P C1 1

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

Approvals

CE, UKCA

Typical Base Materials

316, 316L, 316LN, 316Ti, 318, S31600, S31603, S31653, S31635, S31640, X5 CrNiMo 17-12-2, X2 CrNiMo 17-13-2, X2 CrNiMoN 17-12-2, X6 CrNiMoTi 17-12-2, 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 (+)

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

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
600	490	35	50	-60°C

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