



# WELDING CONSUMABLES

## WIRES FOR MILD STEEL TECHNICAL DATA SHEETS



**50** / A family business  
engineered through  
generations since 1971



**Exclusive partnership**  
Tianjin Bridge Welding  
Materials Group

# WELD STAR | WELDING CONSUMABLES

Founded in 1983 Wilkinson Star is one of the UK's leading importers and wholesale distributors of industrial and welding equipment. We offer a comprehensive range of welding and resistance welding equipment, welder generators, generators and lighting towers along with a comprehensive range of welding consumables, PPE equipment, gas equipment, air compressors, air accessories and air & hand tools.

In our aim to provide unrivalled service and complete customer satisfaction, all our industry leading brands are supported by our world class on site Welding Training Academy/Demonstration Centre and Marketing Services Facility. Furthermore our technical expertise for product innovation and development is at the core of our Technical Support Centre and this has been further enhanced with the addition of the Inverter Technology Centre at Manchester in 2015. We have been assembling air compressors in our Manchester based Fiac Production Facility since 1991.

We offer over 900 man years of knowledge in our industry, offering over 20,000 quality product lines, serving over 2,000 authorised UK outlets and export partners with a strong commitment to widen our product ranges to meet the growing demands of our partners in the years ahead.

**New for 2022** is our acquisition of Wardley Cross, opposite sites to our headquarters. Wardley Cross is not only home to our 2m stockholding of wires and consumables but also our new marketing and design centre and our state of the art 150m<sup>2</sup> exhibition space - the first of its kind in the UK.

## Sales & Technical Support, Ordering & Delivery

Our Customer Sales & Technical Centre is open Monday to Friday 8.30am to 5.00pm. Our national sales team of Area Managers and Technical Engineers cover the whole of the UK and Eire.



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**WILKINSON STAR**

## Tianjin Bridge Welding Materials Group

Founded in 1957, Tianjin Bridge Welding Materials Group is one of the top 3 producers of welding consumables globally.

Located in Xiqing economic development zone of Tianjin city, covering a total area of 1,200,000 square metres, a production area of 868,000 square metres, with an annual production output of over 1,500,000 tonnes. Tianjin Bridge also has production bases in Jinghai district of Tianjin city, Hengyang city of Hunan province, Yinchuan city of Ningxia province, and Changji city of Xinjiang province to ensure continuity of our supply chain.

After 65 years of innovating industry, Tianjin Bridge has developed into a comprehensive company mainly specialising in the research, development and production of premium quality welding materials.

Tianjin Bridge products are currently being exported to more than 130 countries worldwide. The high quality products are used in major industrial sectors including, energy and power, petrochemical, pressure vessels, construction, bridges, ships, marine engineering, rail transit, construction machinery, nuclear power and military installations etc.

Wilkinson Star has the import and export rights for UK, Eire and several parts of mainland Europe. We are looking forward to working with our new exclusive partner.





# SG2 - G3Si1

Mild Steel MIG/GMAW

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 42 4 M21 3Si1

AWS-Classification - ER 70S-6

## Features and Applications

- A copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Vacuum-sealed plastic bag packaging to prevent moisture absorption.
- Fitted with alignment hole clip to ensure smooth feeding.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

## Welding Positions

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

## Shielding Gases

EN ISO 14175 - C1, M21

## Polarity

MAG DC (+)

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.07	0.85	1.45	<0.025	<0.025	<0.35	<0.15	<0.15	<0.15	<0.020	<0.030	<0.15

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010200449	0.80	15	BS300 PLW	72
3010200451	1.00	15	BS300 PLW	72
3010200453	1.20	15	BS300 PLW	72

1kg, 5kg, D300 & Drums also available.

## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-180	80-230	120-350
Voltage (V)	18-22	20-28	26-34

## Mechanical Properties (Typical) - C1

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
540	440	30	70	-30°C

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
580	460	26	90	-40°C

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

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TDS.SG2.BS300.GMAW\_rev1

# SG2 - G3Si1

Mild Steel MIG/GMAW

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 42 4 M21 3Si1

AWS-Classification - ER 70S-6

## Features and Applications

- A copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Vacuum-sealed aluminium foil packaging to prevent moisture absorption.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

## Welding Positions

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

## Shielding Gases

EN ISO 14175 - C1, M21

## Polarity

MAG DC (+)

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.07	0.85	1.45	<0.025	<0.025	<0.35	<0.15	<0.15	<0.15	<0.020	<0.030	<0.15

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010200522	0.60	15	D300 PLW	72
3010200523	0.80	15	D300 PLW	72
3010200525	1.00	15	D300 PLW	72
3010200527	1.20	15	D300 PLW	72
3010200454	1.60	15	D300 PLW	72

1kg, 5kg, BS300 & Drums also available.

## Welding Parameters

Ø mm	0.60	0.80	1.00	1.20	1.60
Current (A)	50-100	60-180	80-230	120-350	220-500
Voltage (V)	15-20	18-22	20-28	26-34	28-38

## Mechanical Properties (Typical) - C1

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
540	440	30	70	-30°C

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
580	460	26	90	-40°C

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

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# SG2 - G3Si1 (ENDURANCE PAC)

Mild Steel MIG/GMAW

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 42 4 M21 3Si1

AWS-Classification - ER 70S-6

## Features and Applications

- Bulk wire drum system that offers a high productivity solution for continuous high volume welding applications.
- A copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



Wire Length	0.80	1.00	1.20
Meters	68,375	43,062	29,625
Miles	42.50	26.76	18.41

## Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

## Welding Positions

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

## Shielding Gases

EN ISO 14175 - C1, M21

## Polarity

MAG DC (+)

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.07	0.85	1.45	<0.025	<0.025	<0.35	<0.15	<0.15	<0.15	<0.020	<0.030	<0.15

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010250080	0.80	250	Drum	4
3010250100	1.00	250	Drum	4
3010250120	1.20	250	Drum	4

1kg, 5kg, D300 & BS300 spools also available.



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## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-180	80-230	120-350
Voltage (V)	18-22	20-28	26-34

## Mechanical Properties (Typical) - C1

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
540	440	30	70	-30°C

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
580	460	26	90	-40°C

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

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TDS.SG2.DRUM.GMAW\_rev1

# SG3 - G4Si1

Mild Steel MIG/GMAW

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 46 4 M21 4Si1

AWS-Classification - ER 70S-6

## Features and Applications

- A copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- The higher Si-Mn content increases the weld metal strength and leaves a good bead appearance.
- Designed for semi-automatic and full-automatic GMAW applications.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Vacuum-sealed aluminium foil packaging to prevent moisture absorption.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



## Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

## Welding Positions

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

## Shielding Gases

EN ISO 14175 - C1, M21

## Polarity

MAG DC (+)

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.08	0.95	1.70	<0.020	<0.020	<0.25	<0.15	<0.15	<0.050	<0.020	<0.030	<0.15

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010301508	0.80	15	D300 PLW	72
3010301510	1.00	15	D300 PLW	72
3010301512	1.20	15	D300 PLW	72

Drums also available.

## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-180	80-230	120-350
Voltage (V)	18-22	20-28	26-34

## Mechanical Properties (Typical) - C1

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
570	460	30	58	-30°C

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
590	490	28	88	-40°C

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

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TDS.SG3.G4Si1.GMAW\_rev1



# SG3 - G4Si1 (ENDURANCE PAC)

Mild Steel **MIG/GMAW**

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 46 4 M21 4Si1

AWS-Classification - ER 70S-6

## Features and Applications

- Bulk wire drum system that offers a high productivity solution for continuous high volume welding applications.
- A copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- The higher Si-Mn content increases the weld metal strength and leaves a good bead appearance.
- Designed for semi-automatic and full-automatic GMAW applications.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
- **Test Certificates can be found online @wilkinsonstar247.com**



Wire Length	0.80	1.00	1.20
Meters	68,375	43,062	29,625
Miles	42.50	26.76	18.41

## Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

## Welding Positions

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

## Shielding Gases

EN ISO 14175 - C1, M21

## Polarity

MAG DC (+)

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu % <sup>a</sup>	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.08	0.95	1.70	<0.020	<0.020	<0.25	<0.15	<0.15	<0.050	<0.020	<0.030	<0.15

<sup>a</sup> (includes copper coating)

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010301514	0.80	250	Drum	4
3010301516	1.00	250	Drum	4
3010301518	1.20	250	Drum	4

D300 spools also available.



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## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-180	80-230	120-350
Voltage (V)	18-22	20-28	26-34

## Mechanical Properties (Typical) - C1

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
570	460	30	58	-30°C

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
590	490	28	88	-40°C

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

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TDS.SG3.DRUM.GMAW\_rev1

# CF2 - G3Si1 (Copper Free)

Mild Steel MIG/GMAW

## Standards

EN/ISO-Standard - 14341-A

AWS-Standard - A5.18

EN/ISO-Classification - G 42 3 C1 / G 42 4 M21 3Si1

AWS-Classification - ER 70S-6

## Features and Applications

- A non-copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- Environmentally friendly when compared against traditional copper wires offering less fume and smoke in the working environment.
- Advantages of a stable arc when working with increased welding speeds that achieves high quality welds with almost no spatter.
- Good mechanical properties at sub-zero temperatures down to -40°C.
- Vacuum-sealed plastic bag packaging to prevent moisture absorption.
- Fitted with alignment hole clip to ensure smooth feeding.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on boilers, industrial machinery, bridges, shipbuilding, automotive, rail, structural and engineering fabrications etc.
- Green wire is produced using virgin raw materials sourced from specialised steel mills, which ensures consistent reliability and quality.
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## Typical Base Materials

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

## Welding Positions

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

## Shielding Gases

EN ISO 14175 - C1, M21

## Polarity

MAG DC (+)

## Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.07	0.85	1.45	<0.025	<0.025	0.010	<0.15	<0.15	<0.15	<0.020	<0.030	<0.15

## Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010200837	0.80	15	BS300 PLW	72
3010200839	1.00	18	BS300 PLW	56
3010200841	1.20	18	BS300 PLW	56

Drums also available.

## Welding Parameters

Ø mm	0.80	1.00	1.20
Current (A)	60-180	80-230	120-350
Voltage (V)	18-22	20-28	26-34

## Mechanical Properties (Typical) - C1

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
540	440	30	70	-30°C

## Mechanical Properties (Typical) - M21

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
580	460	26	90	-40°C

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

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TDS.CF2.G3Si1.GMAW\_rev1

**CF2 - G3Si1** (ENDURANCE PAC)Mild Steel **MIG/GMAW****Standards****EN/ISO-Standard** - 14341-A**AWS-Standard** - A5.18**EN/ISO-Classification** - G 42 3 C1 / G 42 4 M21 3Si1**AWS-Classification** - ER 70S-6**Features and Applications**

- Bulk wire drum system that offers a high productivity solution for continuous high volume welding applications.
- A non-copper coated solid wire suitable for single pass or multipass welding of unalloyed and low-alloyed carbon-manganese steels.
- Environmentally friendly when compared against traditional copper wires offering less fume and smoke in the working environment.
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Wire Length	0.80	1.00	1.20
Meters	68,375	43,062	29,625
Miles	42.50	26.76	18.41

**Typical Base Materials**

S185, S235, S275, S355 - Grade A, B, D, AH32 to DH36 - L210, L240, L290, L360, L240NB, L290NB, L360NB, L360QB, L240MB, L290MB, L360MB, L415MB - X42, X46, X52, X60 - P235T1, P235T2, P275T1 - P275T2, P355N - P235GH, P265GH, P295GH, P355GH - S275, S355, S420, S275M, S275ML, S355M, S355ML, S420M, S420ML\*

\* Illustrative, not exhaustive list

**Welding Positions**

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

**Shielding Gases**

EN ISO 14175 - C1, M21

**Polarity**

MAG DC (+)

**Chemical Composition % (Typical)**

C %	Si %	Mn %	P %	S %	Cu %	Cr %	Ni %	Mo %	Al %	V %	Zr+Ti %
0.07	0.85	1.45	<0.025	<0.025	0.010	<0.15	<0.15	<0.15	<0.020	<0.030	<0.15

**Packaging Data**

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
<b>3010200918</b>	0.80	250	Drum	4
<b>3010200922</b>	1.00	250	Drum	4
<b>3010200926</b>	1.20	250	Drum	4

BS300 spools also available.

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**Welding Parameters**

Ø mm	0.80	1.00	1.20
<b>Current (A)</b>	60-180	80-230	120-350
<b>Voltage (V)</b>	18-22	20-28	26-34

**Mechanical Properties (Typical) - C1**

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
540	440	30	70	-30°C

**Mechanical Properties (Typical) - M21**

Tensile Strength (N/mm <sup>2</sup> )	Yield Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact Strength (J)	Test Temperature
580	460	26	90	-40°C

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



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TDS.CF2.DRUM.GMAW\_rev1

# WELD STAR | WELDING CONSUMABLES



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