



PROSTAR® Premium Quality Tubular Wires

PROSTAR® flux-cored and metal-cored wires represent the latest in tubular wire design and performance. These products offer one of the highest levels of consistency, quality and performance in today's marketplace. Rigorous inspection systems ensure that PROSTAR® tubular wires exhibit the same high quality standards on an everyday basis. New manufacturing technologies provide the ultimate in feedability, weldability and overall performance.

Diameters and Packaging

PROSTAR® Premium Quality Tubular Wires are available in a broad range of diameters (from .030" to 1/8") and in a wide variety of packages.

PROSTAR® Premium Quality Metal-Cored Wire

The continuing search for improvements has led to the development of PROSTAR® metal-cored tubular welding wires. Cleaner strip material with improved surface characteristics, more accurate filling of the wire core, and tighter controls on wire sizing all contribute to making PROSTAR® tubular wire the best of class.

These factors also help to provide exceptional feedability with reduced contact tip wear and superior arc characteristics.

- Higher Deposition Efficiency
- Higher Productivity
- Lower Fume Generation
- Improved Sidewall Fusion
- Improved Metal Transfer
- Better Bead Profile

PROSTAR® Premium Quality Flux Cored Wires

Flux-cored arc welding offers many advantages over solid wires and covered electrodes. Higher deposition rates, better penetration, improved sidewall fusion, and an enhanced ability to weld over some mill scale or rust on the plate surface, with less operator skill, are important advantages of these wires.

Gas-Shielded Flux-Cored Wires

PROSTAR® tubular flux-cored wires are used in applications where the base metal thickness is greater than 1/4" and where the parts to be welded have poor fit-up or contain some amount of dirt, oil, rust or mill scale.

Self-Shielded Flux-Cored Wires

Designed for a work environment subject to crosswinds (i.e. outdoor construction) or for areas where it is difficult to provide cylinders of shielding gas. PROSTAR® self-shielded cored wires are formulated to produce their own shielding environment as a result of the decomposition of components present in the core of the wire and neutralization of the nitrogen gas.



Product Selection Guidelines

Advantages of Flux-Cored vs. Solid Electrodes

1. Higher deposition rates in all position welds
2. Better penetration
3. Elimination of cold lap or lack of fusion
4. Virtually free from subsurface porosity when welded on scaled material

Advantages of Flux-Cored vs. Covered Electrodes

1. Higher deposition rates
2. Higher duty cycles
3. Better penetration

Advantages of Metal-Cored vs. Solid Electrodes

1. More productivity
2. Less spatter and rework
3. Improved sidewall fusion and penetration
4. Better penetration

Advantages of Metal-Cored vs. Flux-Cored

1. Less spatter and no slag to clean up
2. Higher deposition efficiencies



Flux-Cored Arc Welding (FCAW) Wire Solutions

Premium Quality Tubular Wires – Most Popular Products



Gas-Shielded Flux-Cored Wires	AWS Class	Performance Characteristics
PROSTAR® FC-70	E70T-1, E70T-9	Smooth arc, flat bead profile and wide operating range.
PROSTAR® FC-70LF	E70T-1	Less fume and spatter than FC-70. Bead is slightly more convex.
PROSTAR® FC-71F	E71T-1, E71T-1M E71T-9, E71T-9M	Smooth arc, low spatter, good all-position characteristics and low fume with Ar/CO ₂ .
PROSTAR® FC71-C	E71T-1, E71T-9	All-position capability with CO ₂ .
PROSTAR® FC-71 Supreme	E71T-1, E71T-1M E71T-12, E71T-12M	Best welding characteristics, mechanical properties and low fume with Ar/CO ₂ .


Self-Shielded Flux-Cored Wires	AWS Class	Performance Characteristics
PROSTAR® FC-SS-11	E71T-11	All-position, for carbon steel weldments.
PROSTAR® FC-SS-GS	E71T-GS	All-position, for single pass welding of coated steels.


Metal-Cored Wires	AWS Class	Performance Characteristics
PROSTAR® STARCORE 6	E70C-6M	For general-purpose application and low fume.
PROSTAR® STARCORE 6LF	E70C-6M	Lower fume and spatter; best operator appeal and bead shape.
PROSTAR® STARCORE 6LS	E70C-6M	Enhanced mechanical properties with 20 ft. lb. at -50 °F achievable.

Product Regulatory Approvals

PROSTAR® Tubular Wires are approved to various worldwide standards including the American Welding Society (AWS), the Canadian Welding Bureau (CWB), ABS, DnV and Lloyds.

Tubular Wire Comparison Chart

AWS Class		Corex®	Dual Shield®	Hobart®	Lincoln®	Tri-Mark®	Core	Preferred Gas
Flux-Cored – Steel								
E70T-1	PROSTAR® FC-70	FC 7	DS R70	RXR	OS70	TM-72	Flux-Cored	Praxair Mig Mix Gold, C-25
E70T-1	PROSTAR® FC-70LF		DS R70 Ultra	TR70			Flux-Cored	Praxair Carbon Dioxide
E71T-1,1M	PROSTAR® FC-71M	VC 1	DS 7000	825	OS 71	TM-711M	Flux-Cored	Praxair StarGold® C-25
E71T-1,1M	PROSTAR® FC-71LF		DS 7100 Ultra	71	OS 71M	TM777	Flux-Cored	Praxair StarGold® C-25
E71T-1	PROSTAR® FC-71C		DS 7100 Ultra		OS 71M		Flux-Cored	Praxair Carbon Dioxide
E71T-1,1M	PROSTAR® FC-71 SUPREME		DS 7100 Ultra LC				Flux-Cored	Praxair StarGold® C-25

AWS Class		Corex®	Dual Shield®	Hobart®	Lincoln®	Tri-Mark®	Core	Preferred Gas
Metal-Cored – Steel								
E70C-6M	PROSTAR® STARCORE 6	MC 6	CW 70	86R	OS MC710	Met 76	Metal-Cored	Praxair StarGold® C-25
E70C-6M	PROSTAR® STARCORE 6LF	MC 6L	CW Ultra			Met 70X	Metal-Cored	Praxair StarGold® C-25
Flux-Cored – Gasless – Steel								
E71T-11	PROSTAR® FC-SS-11	SS 11	Coreshield 11	FS 21B	IS NR 211MP	TM-121	Flux-Cored	Gasless
E71T-GS	PROSTAR® FC-SS-GS	SS 11GS	Coreshield 15	FS 23	IS NR 151	TM-123	Flux-Cored	Gasless