

TG-X308L

100%Ar.
AWS A5.22 R 308LT1-5
1.4316

TG-X309L

100%Ar.
AWS A5.22 R 309LT1-5
1.4332

TG-X316L

100%Ar.
AWS A5.22 R 316LT1-5
1.4430

TG-X347

100%Ar.
AWS A5.22 R 347LT1-5
1.4551

Description and Application

These are flux cored TIG filler rods for root pass welding of stainless steel pipe without the need for purging (back shielding gas).

In order to get best results, the keyhole technique must be used so as to allow molten slag to flow and completely cover both the face side and back side of the root pass thus protecting the bead against the atmosphere.

TG-X308L is for 18%Cr-8%Ni type stainless steel.

TG-X309L is for dissimilar joints between stainless and mild steel or medium carbon steels.

TG-X316L is for 18%Cr- 12%Ni-2%Mo stainless steel.

TG-X347 is for 18% Cr- 8%Ni +Ti or 18%Cr-8%Ni+ Nb stabilized stainless steel.

Chemical Analysis

	C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb+Ta	FS	FN
TG-X308L	0.02	0.80	1.70	0.023	0.005	10.3	19.6	-	-	-	-	-
TG-X309L	0.02	0.80	1.50	0.022	0.006	12.6	24.3	-	-	-	-	-
TG-X316L	0.02	0.90	1.60	0.023	0.004	12.5	18.9	2.3	-	-	-	-
TG-X347	0.02	0.80	1.60	0.021	0.004	10.2	19.0	-	-	0.7	-	-

Mechanical Properties

	R _e (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	CV (J)	°C
TG-X308L	450	620	47	60	-196
TG-X309L	530	680	32	-	-
TG-X316L	440	600	38	110	0
TG-X347	460	630	48	130	0

Welding Positions

TG-X308L

2.2 mm



TG-X309L

2.2 mm



TG-X316L

2.2 mm



TG-X347

2.2 mm

