

TG-X308L

100%Ar

AWS A5.22 R 308LT1-5
EN 1.4316

TG-X309L

100%Ar

AWS A5.22 R 309LT1-5
EN 1.4332

TG-X316L

100%Ar

AWS A5.22 R 316LT1-5
EN 1.4430

TG-X347

100%Ar

AWS A5.22 R 347T1-5
EN 1.4551

Description and Application

These are all rutile flux cored TIG filler rods for root pass welding of stainless steel pipe without the need for a reverse side back purge (internal shielding gas). As they produce a slag, they are not recommended for multi-pass welding.

TG-X308L is for welding 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.

● Proper root gap

Groove Preparation			
	4 mm	6 mm	10 mm min.
Plate thickness (T)	4 mm	6 mm	10 mm min.
Root gap (G)	2.0 mm	2.5 mm	3.0 mm

Typical Chemical Analysis (wt. %)

	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	-	-	-	9	13
TG-X309L	0.02	0.80	1.50	0.022	0.006	12.6	24.3	-	-	-	14	>18
TG-X316L	0.02	0.90	1.60	0.023	0.004	12.5	18.9	2.3	-	-	8	13
TG-X347	0.02	0.80	1.60	0.021	0.004	10.2	19.0	-	-	0.7	9	13

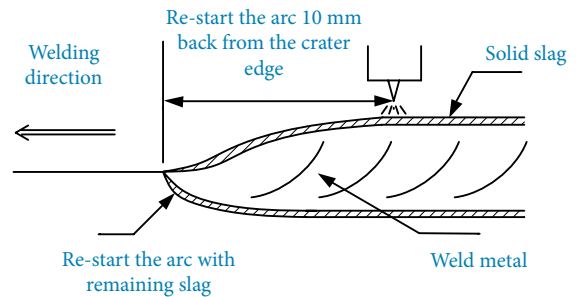
Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	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

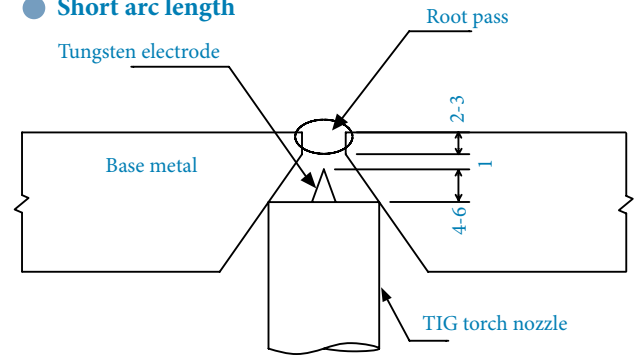
Welding Positions



● Proper bead connection



● Short arc length



● Proper keyhole technique

