

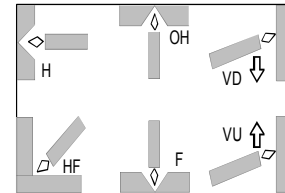
One-side TIG Welding

TG-X347
FAMILIARC
Flux cored filler rod for 18%Cr-8%Ni-Nb and 18%Cr-8Ni-Ti stainless steel
Classification: ASME / AWS A5.22 R347T1-5

Features : •Applicable for 347 and 321 type steels
 •Suitable for root pass in one-side TIG welding without back shielding

Shielding gas: Ar

Polarity: DC-EN

Welding positions:

Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.020	0.80	1.60	0.021	0.004
Guaranty	≤0.08	≤1.20	0.50~2.50	≤0.040	≤0.030
	Ni	Cr	Nb+Ta	Mo	Cu
Example	10.21	19.09	0.66	0.02	0.03
Guaranty	9.00~11.00	18.00~21.00	8xC%~1.0	≤0.50	≤0.50

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	460	630	48	0°C: 130
Guaranty	-	≥520	≥30	-

Recommended welding parameters

Plate thickness	Welding current
3~5mm	80~ 90A
6~9mm	90~105A
≥10mm	90~110A

Packages

Dia. (mm)	Type	Weight (kg)	Length (mm)	Weight per piece (g)
2.2	tube	5	1,000	25