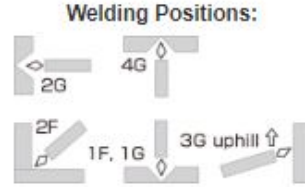


PREMIARC™ TG-X309L

Flux cored filler rod

- Features:**
- Applicable for dissimilar-metal joint of stainless steels and ferritic steels
 - Suitable for root pass in one-side welding without back shielding
 - In order to avoid defects, TG-X filler rod must be moved quickly at short pitch, unlike TIG filler rod

Classification: AWS A5.22 R309LT1-5
Shielding gas: Ar
Identification color: Yellow green
Polarity: DCEN



Packaging data

			Tube	
φ mm	kg	Length mm	g/piece	Volume mm
2.2	5	1,000	26	42W, 35H, 1015L

Composition (all-weld metal mass %)

	Typical	Guaranty ^a
C	0.02	0.03
Si	0.8	1.2
Mn	1.4	0.5-2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.1	12.0-14.0
Cr	23.7	22.0-25.0
Mo	0.02	0.75
Cu	0.04	0.75
Bi	>0.002	-

Note: ^aSingle values are maximum.

Welding parameters (A)

thickness mm	3-5	6-9	Over 10
current A	80-90	90-105	90-110

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	530	-
TS (MPa)	680	518min.
EI on 4d (%)	32	30min.

Diam.	Part No.
2.2mm	KOBE TGX309L

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