

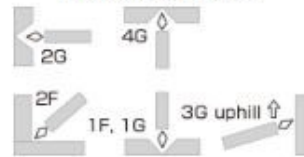
PREMIARC™ TG-X347

Flux cored filler rod

- Features:**
- Applicable for 347 and 321 type steels
 - Suitable for root pass in one-side TIG 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 R347T1-5
Shielding gas: Ar
Identification color: Blue
Polarity: DCEN

Welding Positions:



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 | 0.08 |
| Si | 0.8 | 1.2 |
| Mn | 1.4 | 0.5-2.5 |
| P | 0.02 | 0.04 |
| S | <0.01 | 0.03 |
| Ni | 10.2 | 9.0-11.0 |
| Cr | 18.9 | 18.0-21.0 |
| Nb+Ta | 0.60 | 8xC%-1.0 |
| Mo | 0.01 | 0.75 |
| Cu | 0.03 | 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) | 460 | - |
| TS (MPa) | 630 | 518min. |
| EI on 4d (%) | 48 | 30min. |
| IV 0°C (J) | 130 | - |

| Diam. | Part No. |
|-------|--------------|
| 2.2mm | KOBE TGX347L |

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