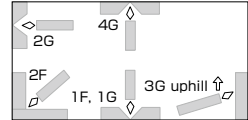


TG-X316L

Flux cored filler rod

- Features:**
- Applicable for 316 and 316L 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

Welding Positions:



Classification: AWS A5.22 R316LT1-5

Shielding gas: Ar

Identification color: Green

Polarity: DCEN

Packaging data

φ mm	Tube			
	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	0.7	1.2
Mn	1.4	0.5~2.5
P	0.02	0.04
S	<0.01	0.03
Ni	12.0	11.0~14.0
Cr	18.4	17.0~20.0
Mo	2.2	2.0~3.0
Cu	0.05	0.75
Bi	>0.002	-

Note: ^aSingle values are maximum.

Welding parameters

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)	440	-
TS (MPa)	600	483min.
El on 4d (%)	38	30min.
IV 0°C (J)	110	-