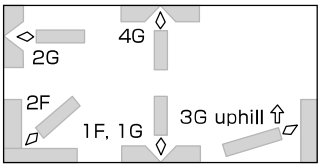
TG-X309L PREMIARC™

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

Welding Positions:



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: [a] Single 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)	530	-
TS (MPa)	680	518min.
El on 4d (%)	32	30min.