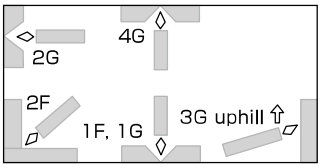
TG-X347 PREMIARC™

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

Welding Positions:



Classification: AWS A5.22 R347T1-5

Shielding gas: Ar
Identification color: Blue
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	0.08
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: [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)	460	-
TS (MPa)	630	518min.
El on 4d (%)	48	30min.
IV 0℃ (J)	130	-