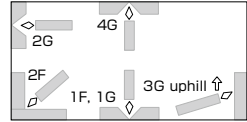


## Flux cored filler rod

### 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

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

## Composition (all-weld metal mass%)

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

Note: <sup>a</sup>Single values are maximum.

## Welding parameters

thickness mm	3~5	6~9	Over 10
<b>current A</b>	80~90	90~105	90~110

## All-weld mechanical properties

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