



Quality Management System  
in accordance with  
**ISO 9001:2000**  
Cert # 05-R0925

# STAINLESS STEEL Flux Cored Tig

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



## ALLOY DESCRIPTION AND APPLICATION;

These flux cored rods are primarily used for the root pass on piping where backing and purging gas may not be possible or desirable. This rod should be used as a basic tig rod on DCEN, however caution is advised due to the easily removable slag covering that must be removed prior to addition welding.

## TYPICAL GTAW WELDING PROCEDURES; DCEN 100% Argon

Wire Diameter	Amps	Volts
2.2mm (.087")	100-250	12-13

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

## TYPICAL UNDILUTED METAL CHEMISTRY (%) per AWS A5.22;

Grade <sup>1)</sup>	Chemistry				Intended Use
	C	Cr	Ni	Mo	
R308L	0.03	18.0-21.0	9.0-11.0	0.50	Welding of 18Cr & 8Ni such as 304, 304L
R309L	0.03	22.0-25.0	12.0-14.0	0.50	Welding of carbon steel to austenitic stainless
R316L	0.03	17.0-20.0	11.0-14.0	2.0-3.0	Primarily use on 316 or 316L
R347 <sup>2)</sup>	0.08	18.0-21.0	9.0-11.0	0.50	Primarily use on 347

1) All grades has the following : Mn=0.50-2.5, Si=1.2, P=0.04, S=0.03 Cu=0.50 Single values are maximum

2) R347 also has Cb+Ta =8xCmin. -1.0 max.

Grade	Tensile Strength, minimum	Elongation Percent, minimum
R308L	75,000	35
R309L	75,000	30
R316L	70,000	30
R347	75,000	30

**AVAILABLE SIZES:** TST 308LT1-5 = Rods of 2.2mm x 915mm  
TST 309LT1-5 = Rods of 2.2mm x 915mm  
TST 316LT1-5 = Rods of 2.2mm x 915mm  
TST 347LT1-5 = Rods of 2.2mm x 915mm

**SPECIFICATIONS:** Washington Alloy per AWS for stainless flux cored rods chemistry only

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