

DUROARC 316L TMX/TGX ROD

AWS A5.22 R316LT1-5

DESCRIPTION

DuroArc 316L TMX/TGX is a stainless steel flux-cored rod for TIG welding without back shielding. Used for root pass to produce slag that protects reverse side bead from oxidation by the atmosphere. Provides regular penetration through the entire part of the pipe in all positions. Use TGX flux-cored filler rods eliminates gas purging procedures. No backing gas required.

Typical application: Used for stainless steel pipe welding. Applicable for 316 and 316L steels.

SPECIFICATIONS

Weld Deposit Properties:

Tensile Strength: 535 PSI (MPa) Elongation: 35%

CHEMICAL COMPOSITION (TYPICAL WEIGHT %)

Item	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Typical Value	0.027	1.38	0.52	0.012	0.009	12.50	18.89	2.45	0.01

WELDING PROCEDURES DC (+)

The oil stains and rust on the weldments should be cleared away.

Designed for welding with 100% Ar.

When welding, the gas flow rate is generally 10~15L/min

Move tig wire quickly at short pitch to avoid defects

Welding Positions



Thickness (mm)	Root gap (mm)	Root face (mm)	Current (A)
3-5mm	2.0	1.0	80-100
6-9mm	2.5	1.0	90-120
over 10mm	3.0	1.0	100-150

Diameter	2.4mm (3/32")
Amperage	90-150

PACKAGING

Diameter	2.4mm (3/32")
Tube (kg)	5kg (11lb)