

DUROARC 309TMX/TGX ROD

AWS A5.22 R309LT1-5

DESCRIPTION

DuroArc 309 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 dissimilar-metal joint of stainless steels and ferritic steels.

SPECIFICATIONS

Weld Deposit Properties:

Tensile Strength: 560 PSI (MPa)

Elongation: 38%

CHEMICAL COMPOSITION (TYPICAL WEIGHT %)

| Item | C | Mn | Si | P | S | Ni | Cr | Mo | Cu |
|---------------|-------|------|------|-------|-------|-------|-------|------|------|
| Typical Value | 0.022 | 1.45 | 0.45 | 0.012 | 0.009 | 13.50 | 23.45 | 0.03 | 0.02 |

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 (10lb) |