



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

# STAINLESS STEEL Flux Coated 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 coated rods are primarily used for the root pass on piping where backing and purging gas may not be possible or desirable. This 39" 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

Wire Diameter	Amps	Volts
5/64"	90-180	12-13
3/32"	150-250	12-13
1/8"	200-375	12-14

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
R308H <sup>3)</sup>	0.04-0.08	19.5-22.0	9.0-11.0	0.50	Welding of 18Cr & 8Ni such as 304, 304H
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.
- 3) R 308H is not listed in AWS; the chemistry is from E308HTO-3 per AWS A5.22 which provides higher strengths at elevated temperatures.

**AVAILABLE SIZES:** TFT 308L= Rods of 3/32, 1/8  
TFT 308H= Rods of 3/32, 1/8  
TFT 309L= Rods of 3/32, 1/8  
TFT 316L= Rods of 5/64,3/32, 1/8  
TFT 347 = Rods of 3/32, 1/8

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

**EAST COAST**  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

**GULF COAST**  
4855 Alpine Drive #190  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

**WEST COAST**  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586



6-2009 DC

Washington Alloy Company believes that all information and data given is correct. Use this information to assist in making your own evaluations or decisions and this information should not be mistaken as an expressed or implied warranty. U.S. ALLOY CO. assumes no liability for results or damages incurred from the use of any information contained herein, in whole or in part.