



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

STAINLESS STEEL Flux Coated Tig

U.S. ALLOY CO.
dba Washington Alloy
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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 3/32" 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 ¹⁾	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 ³⁾	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 ²⁾	0.08	18.0-21.0	9.0-11.0	0.50	Primarily use on 347
R2594 ⁴⁾	0.04	24.0-27.0	8.0-10.5	2.5-4.5	Super duplex stainless steel

- 1) All grades has the following : Mn=0.50-2.5, Si=1.2, P=0.04, S=0.03 Cu=0.50 except 2594 Cu=1.5 S single values are maximum
- 2) R347 also has Cb+Ta =8xCmin. -1.0 max.
- 3) R308H is not listed in AWS; the chemistry is from E308HTO-3 per AWS A5.22 which provides higher strengths at elevated temperatures.
- 4) R 2594 has N= 0.2-0.3

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
TFT 2594 = Rods of 1/8

SPECIFICATIONS: Washington Alloy per AWS for stainless flux cored rods chemistry only,
No AWS specification

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