

TFW-308LT

AWS A5.22 E308LT0-1
EN ISO 17633-A-T 19 9 L R C1 3
JIS Z 3323 TS 308L-F C 1 0

Characteristics and Applications:

TFW-308LT is designed for Flat position welding by gas shield of 100% CO₂. It has very excellent slag-removal property. An austenitic stainless steel deposit that can be used for joining common austenitic steels such as Types 304,304L, 321, CF-8, and CF-3. It provides good resistance to intergranular corrosion.

Notes on usage:

1. Before welding, the base material should be cleaned from oil, rusty, moisture and it should have the proper protection from the wind in welding site.
2. Use with 100% CO₂.
3. Keep the product dry, while it is stored or delivered.

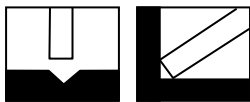
Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni
0.025	1.53	0.56	0.023	0.008	19.31	9.63

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
584(85)	38

Welding position:



Sizes and recommended parameter range (DC < + >):

Stick out:15-20(mm),flow rate:20-25(l/min):

Diameter (mm)	1.2
Position	
F, HF	130A-220A/24V-33V

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