

TFW-309LT

AWS A5.22 E309LT0-1
EN ISO 17633-A-T 23 12 L R C1 3
JIS Z 3323 TS 309L-F C 1 0

Characteristics and Applications:

TFW-309LT is designed for Flat position welding by gas shield of mix gas (75~80% Argon and 25~20% CO₂). The weld metal of TFW-309L contains 24% Cr and 13% Ni. It is commonly used for welding similar alloys in wrought or cast forms, also used in welding dissimilar metals, such as joining Type 304 to mild steel.

Notes on usage:

1. Before welding, oil, rusty, and moisture should be cleaned off the base material that should have the proper protection from the wind in welding site.
2. Use with 100% CO₂ gas.
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
0.024	1.62	0.62	0.022	0.009	24.07	12.33

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
580(84)	34

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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