

# TFW-316L

AWS A5.22 E316LT1-1  
EN ISO 17633-A-T 19 12 3 L P C1 1  
JIS Z 3323 TS 316L-F C 1 1

## Characteristics and Applications:

TFW-316L is designed for 100% CO<sub>2</sub> gas shielding and all-position welding. It exhibits excellent slag release and almost spatter-free operating features. It can be used for joining types of 316,316L, CF-8M, and CF-3M stainless steels. It provides high inter-granular corrosion resistance to pressure vessel application due to the low carbon content.

## 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 99.8% purity or higher CO<sub>2</sub> shielding 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	Mo
0.026	1.39	0.55	0.024	0.007	19.10	12.36	2.22

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
560(81)	42

## Welding position:



## Size and recommended parameter range (DC <+>)

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

Position	Diameter (mm)	1.2	1.6
	F		130-220A / 23~33V
HF		140-220A / 23~33V	200A-300A / 27V-35V
V-UP		120-200A / 24~30V	160A-200A / 24V-27V
OH		150-180A / 25-29V	--

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