

# TFW-317L

AWS A5.22 E317LT1-1  
JIS Z 3323 TS 317L-F C 1 1

## Characteristics and Applications:

TFW-317L is designed for 100% CO<sub>2</sub> gas shielding and all-position welding wire. It is used for joining types of stainless steels such as 317, 317L, 316, 316L, 316LN, CF-8M and CF-3M. The weld metal exhibits excellent performance of pitting inter-granular corrosion resistance. Common applications include offshore fabrication, chemical tankers as well as petro-chemical, pulp and paper industries.

## Notes on usage:

1. Clean up the contaminations on the base metal.
2. Use 99.8% or higher purity CO<sub>2</sub> as 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	Ni	Cr	Mo
0.027	1.32	0.59	0.028	0.007	13.14	19.20	3.57

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
620(90)	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, H	140A-220A/23V-33V
V-UP, OH	120A-200A/24V-30V

\* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.