

TFW-316LP

AWS A5.22 E316LT1-4
EN ISO 17633-A T 19 12 3 L P M21 1

Characteristics and Applications:

TFW-316LP is designed for all position welding by gas shield of mix gas (75~80% Argon and 25~20% CO₂). An austenitic stainless steel deposit can be used for joining Types 316,316L,CF-8M, and CF-3M stainless steels. The product provides high resistance to inter-granular corrosion with low carbon weld deposit.

Notes on usage:

- 1.Before welding, the base metal should be cleaned from oil, rusty, moisture and it should have the proper protection from the wind in welding site.
- 2.Use with mix gas (75~80% Argon and 25~20% CO₂).

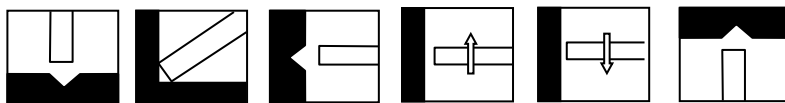
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
AWS	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	17.0-20.0	11.0-14.0	2.0-3.0	≤ 0.75
EN ISO	≤ 0.04	≤ 2.0	≤ 1.2	≤ 0.030	≤ 0.025	17.0-20.0	10.0-13.0	2.5-3.0	≤ 0.5
Typical value	0.026	1.35	0.49	0.023	0.010	18.95	12.52	2.70	0.05

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≥ 485(70)	≥ 30
EN ISO	≥ 320(46)	≥ 510(74)	≥ 25
Typical value	460(67)	629(91)	38

Welding position:



Size and recommended parameter range (DC <+>)

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

Position	Diameter (mm)	1.2
F, HF		130A-220A/24V-33V
H		140A-180A/25V-29V
V-UP		130A-180A/24V-28V
V-down		150A-180A/25V-29V
OH		150A-180A/25V-29V

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