TFW-309LP

AWS A5.22 E309LT1-4
EN ISO 17633-A-T 23 12 L P M21 1

Characteristics and Applications:

TFW-309LP is designed for all position welding by gas shield of mix gas (75～80% Argon and 25～20% CO_2). The weld metal of TFW-309LP contains 24% Cr and 13% Ni. It is commonly used for welding similar alloys in wrought or cast forms, as well as welding dissimilar metals, such as joining Type 304 to mild steel. It can also be used as an intermediate layer for hard facing.

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% CO_2).

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	21.0-25.0	12.0-16.0	2.0-3.0	≦ 0.75
EN ISO	≦ 0.04	≦2.5	≦ 1.2	≦ 0.030	≦ 0.025	22.0-25.0	11.0-14.0	2.0-3.0	≦ 0.5
Typical value	0.028	1.58	0.58	0.022	0.008	24.02	13.01	2.26	0.05

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≧520(75)	≧25
EN ISO	≧320(46)	≧550(80)	≧25
Typical value	565(82)	595(86)	37

Welding position:

Sizes 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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TIENTAI
AN ILLINOIS TOOL WORKS COMPANY
No.6, Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan
TEL:886-6-2663721 /FAX:886-6-2664301
E-mail:twtrad@itwweld.com
http://www.tientai.com