

TFW-308L

AWS A5.22 E308LT1-1
EN ISO 17633-A-T 19 9 L P C1 1
JIS Z 3323 TS308L-F C 1

Characteristics and Applications:

TFW-308L is designed for 100% CO₂ gas shielding and all-position welding. It exhibits excellent slag detachability. And almost spatter-free operating features can be used for joining of austenitic steels such as Types 304, 304L, 321, CF-8, and CF-3. It also provides better inter-granular corrosion resistance due to a low carbon weld deposit.

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 CO₂ 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	Cu
AWS	≤ 0.04	0.5-2.4	≤ 1.0	≤ 0.04	≤ 0.03	18.0-21.0	9.0-11.0	≤ 0.75	≤ 0.75
EN ISO	≤ 0.04	0.5-2.5	≤ 1.2	≤ 0.030	≤ 0.025	18.0-21.0	9.0-11.0	≤ 0.3	≤ 0.5
Typical value	0.026	1.40	0.50	0.023	0.008	19.50	9.80	0.82	0.12

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	-	-
EN ISO	≥ 320(46)	≥ 510(74)	≥ 30
Typical value	460(67)	565(82)	40

Welding position:



Sizes and recommended operating range (DC <+>):

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

Position	Diameter (mm)	1.2	1.6
	F, HF		130A-220A / 24V-33V
H		140A-180A / 25V-29V	200A-300A / 27V-35V
V-UP		130A-160A / 24V-28V	160A-200A / 24V-27V
OH		150A-180A / 25V-29V	-

* 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.