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% CO_2 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 CO_2 shielding gas.
3. Keep the product dry, while it is stored or delivered.

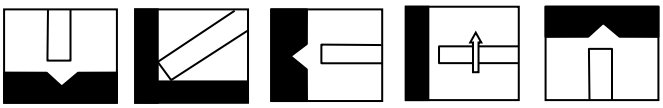
Typical chemical composition of weld metal (wt%):

	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	150A-220A / 24V-33V	200A-300A / 27V-35V
H	140A-200A / 25V-29V	200A-300A / 27V-35V
V-UP	130A-160A / 24V-28V	160A-200A / 24V-27V
OH	150A-180A / 25V-29V	-

FLUX CORED WIRES

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