IIIX CORFD WIRE

TFW-308LTM

AWS A5.22 E308LT0-4 EN ISO 17633-A-T 19 9 L R M21 3 JIS Z 3323 TS308L-F M 0

Characteristics and Applications:

TFW-308LTM is designed for Flat position welding by gas shield of mix gas ($75\sim80\%$ Argon and $25\sim20\%$ CO₂). It features excellent slag-removal property. An austenitic stainless steel deposit can be used for joining common austenitic steels such as Types 304,304L, 321, CF-8, and CF-3. It provides good resistance to intergranular corrosion.

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 with mix gas (75 \sim 80% Argon and 25 \sim 20% CO₂).
- 3. Keep the product dry, while it is stored or delivered.

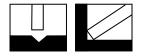
Typical chemical composition of weld metal (wt%):

	С	Mn	Si	Р	S	Cr	Ni	Мо	Cu
AWS	≦ 0.04	0.5-2.5	≦ 1.0	≦ 0.04	≦ 0.03	18.0-21.0	9.0-11.0	≦ 0.75	≦ 0.75
EN ISO	≦ 0.04	≦ 2.0	≦ 1.2	≦ 0.030	≦ 0.025	18.0-21.0	9.0-11.0	≦ 0.3	≦ 0.5
Typical value	0.024	1.60	0.53	0.022	0.007	19.5	9.56	0.08	0.13

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≥520(75)	≥30
EN ISO	≧320(46)	≥510(74)	≧30
Typical value	420(61)	586(85)	38

Welding position:



Sizes and recommended parameter range (DC<+>): Stick out:15-20(mm),flow rate:20-25(I/min):

Diameter (mm) Position	1.2	1.6
F, HF	150A-220A / 25V-33V	200A-300A / 27V-35V

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