

TFW-309LT

AWS A5.22 E309LT0-1
EN ISO 17633-A-T 23 12 L R C1 3
JIS Z 3323 TS309L-F C 0

Characteristics and Applications:

TFW-309LT is designed for Flat position welding by gas shield of CO₂. The weld metal contains 24% Cr and 13% Ni. It is commonly used for welding similar alloys in wrought or cast forms, also used in welding dissimilar metals, such as joining Type 304 to mild steel.

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 100% CO₂ 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
AWS	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	22.0-25.0	12.0-14.0
EN ISO	≤ 0.04	≤ 2.5	≤ 1.2	≤ 0.030	≤ 0.025	22.0-25.0	11.0-14.0
Typical value	0.024	1.62	0.62	0.022	0.009	24.07	12.33

Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %
AWS	≥ 520(75)	≥ 30
EN ISO	≥ 510(74)	≥ 25
Typical value	580(84)	34

Welding position:



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

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

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

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