

# TFW-309LTM

AWS A5.22 E309LT0-4  
EN ISO 17633-A-T 23 12 L R M21 3  
JIS Z 3323 TS309L-F M 0

## Characteristics and Applications:

TFW-309LTM is designed for flat position welding by gas shield of mix gas (75~80% Argon and 25~20% CO<sub>2</sub>). 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 mix gas (75~80% Argon and 25~20% CO<sub>2</sub>).
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	0.022	1.63	0.66	0.022	0.008	23.65	12.85

## Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %
AWS	≥ 520(75)	≥ 30
EN ISO	≥ 510(74)	≥ 25
Typical value	550(80)	36

## Welding position:



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

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

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

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