TFW-317L

AWS A5.22 E317LT1-1 EN ISO 17633-B-TS 317L-F C1 1 JIS Z 3323 TS317L-F C 1

Characteristics and Applications:

TFW-317L is designed for 100% CO₂ gas shielding and all-position welding wire. It is used for joining types of stainless steels such as 317, 317L, 316, 316L, 316LN, CF-8M and CF-3M. The weld metal exhibits excellent performance of pitting inter-granular corrosion resistance. Common applications include offshore fabrication, chemical tankers as well as petro-chemical, pulp and paper industries.

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.

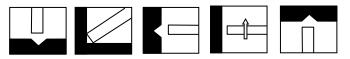
Typical chemical composition of weld metal (wt%):

	С	Mn	Si	Р	S	Ni	Cr	Мо	Cu
AWS	≦ 0.04	0.5-2.5	≦ 1.0	≦ 0.04	≦ 0.03	12.0-14.0	18.0-21.0	3.0-4.0	≦ 0.75
EN ISO	≦ 0.04	0.5-2.5	≦ 1.0	≦ 0.04	≦ 0.03	12.0-14.0	18.0-21.0	3.0-4.0	≦ 0.75
Typical value	0.027	1.32	0.59	0.028	0.007	13.14	19.20	3.57	0.10

Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %
AWS	≧ 520(75)	≧ 20
EN ISO	≥520(75)	≧18
Typical value	620(90)	34

Welding position:



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

Diameter (mm) Position	1.2
F, H	140A-220A/24V-33V
V-UP, OH	130A-200A/24V-30V

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