

# TFW-308H

AWS A5.22 E308HT1-1  
JIS Z 3323 TS 308H-F C 1 1

## Characteristics and Applications:

TFW-308H is designed for 100% CO<sub>2</sub> gas and all-position welding. It exhibits excellent slag release. An 19Cr-9Ni austenitic stainless steel deposited can be used for joining 18Cr-8Ni austenitic steels such as AISI304. AISI301. 302. SUS304H. It provides good resistance to inter-granular corrosion and has higher tensile strength than TFW-308L. It also can be used as an intermediate layer for hardfacing.

## 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<sub>2</sub> 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	0.04-0.08	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	18.0-21.0	9.0-11.0	≤ 0.75	≤ 0.75
Typical value	0.05	1.50	0.50	0.023	0.008	19.90	9.80	0.07	0.15

## Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %
AWS	≥ 550(80)	≥ 30
Typical value	586(85)	40

## Welding position:



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

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

Position	Diameter (mm)	1.2
F		150-240A / 24~32V
H		140-240A / 24~32V
VU、OH		130-200A / 24~28V

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