TFW-308H

Characteristics and Applications:

TFW-308H is designed for 100% CO_2 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_2 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

FLUX CORED WIRES