

TFW-308L

AWS A5.22 E308LT1-1
EN ISO 17633-A-T 19 9 L P C1 1
JIS Z 3323 TS308L-F C 1

Characteristics and Applications:

TFW-308L is designed for 100% CO₂ gas shielding and all-position welding. It exhibits excellent slag detachability. And almost spatter-free operating features can be used for joining of austenitic steels such as Types 304, 304L, 321, CF-8, and CF-3. It also provides better inter-granular corrosion resistance due to a low carbon weld deposit.

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 CO₂ 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	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	18.0-21.0	9.0-11.0	≤ 0.75	≤ 0.75
EN ISO	≤ 0.04	≤ 2.0	≤ 1.2	≤ 0.030	≤ 0.025	18.0-21.0	9.0-11.0	≤ 0.3	≤ 0.5
Typical value	0.026	1.40	0.50	0.023	0.008	19.50	9.80	0.08	0.12

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≥ 520(75)	≥ 30
EN ISO	≥ 320(46)	≥ 510(74)	≥ 30
Typical value	460(67)	565(82)	40

Welding position:



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

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

Position	Diameter (mm)	1.2	1.6
	F, HF		150A-240A / 24V-32V
H		140A-240A / 25V-32V	180A-300A / 27V-35V
V-UP		130A-160A / 24V-28V	160A-200A / 24V-28V
OH		150A-180A / 25V-28V	-

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