

# TFW-308LT

AWS A5.22 E308LT0-1  
EN ISO 17633-A-T 19 9 L R C1 3  
JIS Z 3323 TS308L-F C 1 0

## Characteristics and Applications:

TFW-308LT is designed for Flat position welding by gas shield of 100% CO<sub>2</sub>. It has very excellent slag-removal property. An austenitic stainless steel deposit that can be used for joining common austenitic steels such as Types 304,304L, 321, CF-8, and CF-3. It provides good resistance to intergranular corrosion.

## Notes on usage:

1. Before welding, the base material should be cleaned from oil, rusty, moisture and it should have the proper protection from the wind in welding site.
2. Use with 100% 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	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	0.025	1.53	0.56	0.023	0.008	19.31	9.63	0.075	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	400(58)	584(85)	38

## 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-240A/25V-32V

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