

# TFW-308LTM

AWS A5.22 E308LT0-4  
EN ISO 17633-A-T 19 9 L R M21 3  
JIS Z 3323 TS308L-F M 0

## Characteristics and Applications:

TFW-308LTM is designed for Flat position welding by gas shield of mix gas (75~80% Argon and 25~20% CO<sub>2</sub>). It features excellent slag-removal property. An austenitic stainless steel deposit 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, 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 with mix gas (75~80% Argon and 25~20% 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	0.024	1.60	0.53	0.022	0.007	19.5	9.56	0.08	0.13

## 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	420(61)	586(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-30V	180A-300A / 27V-35V

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