

# TFW-317L

AWS A5.22 E317LT1-1  
EN ISO 17633-B-TS 317L-F C1 1  
JIS Z 3323 TS317L-F C 1

## Characteristics and Applications:

TFW-317L is designed for 100% CO<sub>2</sub> gas shielding and all-position welding wire. It is used for joining types of stainless steels such as 317, 317L, 316, 316L, 316LN, CF-8M and CF-3M. The weld metal exhibits excellent performance of pitting inter-granular corrosion resistance. Common applications include offshore fabrication, chemical tankers as well as petro-chemical, pulp and paper industries.

## 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	Ni	Cr	Mo	Cu
AWS	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	12.0-14.0	18.0-21.0	3.0-4.0	≤ 0.75
EN ISO	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	12.0-14.0	18.0-21.0	3.0-4.0	≤ 0.75
Typical value	0.027	1.32	0.59	0.028	0.007	13.14	19.20	3.57	0.10

## Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %
AWS	≥ 520(75)	≥ 20
EN ISO	≥ 520(75)	≥ 18
Typical value	620(90)	34

## Welding position:



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

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

Diameter (mm)	1.2
Position	
F, H	140A-240A/24V-32V
V-UP, OH	130A-200A/24V-28V

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