

TFW-308H

AWS A5.22 E308HT1-1
JIS Z 3323 TS 308H-F C 1 1

Characteristics and Applications:

TFW-308H is special for 100% CO₂ gas and all-position welding. It owns 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 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
0.05	1.50	0.50	0.023	0.008	19.90	9.80

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
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		140-220A / 23~33V
H		140-220A / 23~33V
VU OH		120-200A / 24~30V

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