

TFW-308LP

AWS A5.22 E308LT1-4
EN ISO 17633-A T 19 9 L P M21 1

Characteristics and Applications:

TFW-308LP is designed for all position welding by gas shield of mix gas (75 80% Argon and 25 20% CO₂). It features excellent slag detachability. 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, the base metal should be cleaned from oil, rusty, moisture and it should have the proper protection from the wind in welding site.
2. Use with mix gas (75 80% Argon and 25 20% CO₂).
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 |
|-------|------|------|-------|-------|-------|------|
| 0.025 | 1.62 | 0.45 | 0.022 | 0.009 | 20.67 | 9.33 |

Typical mechanical properties of weld metal:

| Tensile strength MPa(ksi) | Elongation % |
|------------------------------|-----------------|
| 582(84) | 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 |
|----------|---------------|-------------------|
| 1F, HF | | 130A-220A/24V-33V |
| H | | 140A-180A/25V-29V |
| V-UP | | 130A-180A/24V-29V |
| V-down | | 150A-180A/25V-29V |
| OH | | 150A-180A/25V-29V |

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