

## Characteristics and Applications:

TFW-309L is designed for 100% CO<sub>2</sub> gas shielding and all position welding. It is commonly used for welding similar alloys in wrought or cast forms, or used in dissimilar welding, such as low alloy steel, heat-resistant steel and clad steel.

## 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	Cr	Ni
0.026	1.40	0.55	0.021	0.008	24.07	12.78

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
546 (79)	36

## Welding position:

## Sizes and r

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