

# TFW-309LP

AWS A5.22 E309LT1-4  
EN ISO 17633-AT 23 12 L P M21 1

## Characteristics and Applications:

TFW-309LP is designed for all position welding by gas shield of mix gas (75 80% Argon and 25 20% CO<sub>2</sub>). The weld metal of TFW-309LP contains 24 Cr and 13 Ni. It is commonly used for welding similar alloys in wrought or cast forms, as well as welding dissimilar metals, such as joining Type 304 to mild steel. It can also be used as an intermediate layer for hard facing.

## 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% CO<sub>2</sub>).

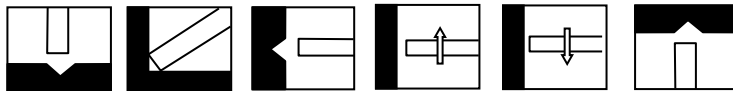
## Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni
0.028	1.58	0.58	0.022	0.008	24.02	13.01

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
565(82)	37

## 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, HF		130A-220A/24V-33V
H		140A-180A/25V-29V
V-UP		130A-180A/24V-28V
V-down		150A-180A/25V-29V
OH		150A-180A/25V-29V

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