

# TFW-309LT

AWS A5.22 E309LT0-1  
EN ISO 17633-A-T 23 12 L R C1 3  
JIS Z 3323 TS 309L-F C 1 0

## Characteristics and Applications:

TFW-309LT is designed for Flat position welding by gas shield of mix gas (75q 80% Argon and 25q 20% CO<sub>2</sub>). The weld metal of TFW-309L contains 24pCr and 13pNi. It is commonly used for welding similar alloys in wrought or cast forms, also used in welding dissimilar metals, such as joining Type 304 to mild 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 with 100% CO<sub>2</sub> 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
0.024	1.62	0.62	0.022	0.009	24.07	12.33

## Typical mechanical properties of weld metal :

Tensile strength MPa(ksi)	Elongation %
580(84)	34

## Welding position:



## Sizes and recommended parameter range (DCpE+PI):

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

Position	Diameter (mm)	1.2
F, HF		130A-220A/24V-33V

FLUX CORED WIRES

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