

TFW-316LP

AWS A5.22 E316LT1-4
EN ISO 17633-A T 19 12 3 L P M21 1

Characteristics and Applications:

TFW-316LP is designed for all position welding by gas shield of mix gas (75 80% Argon and 25 20% CO₂). An austenitic stainless steel deposit can be used for joining Types 316,316L,CF-8M, and CF-3M stainless steels. The product provides high resistance to inter-granular corrosion with low carbon weld deposit.

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).

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Cr	Ni	Mo
0.026	1.35	0.49	0.023	0.010	18.95	12.52	2.70

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
629(91)	38

Welding position:



Size and recommended parameter range (DC +)

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

Position	Diameter (mm)	1.2
	F, HF	
H		140A-180A/25V-29V
V-UP		130A-180A/24V-28V
V-down		150A-180A/25V-29V
OH		150A-180A/25V-29V

FLUX CORED WIRES

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