

# TFW-316LT

AWS A5.22 E316LT0-1  
EN ISO 17633-A-T 19 12 3 L R C 1 3  
JIS Z 3323 TS 316L-F C 1 0

## Characteristics and Applications:

TFW-316LT is designed for flat position welding by gas shield of CO<sub>2</sub> gas. An austenitic stainless steel deposited that can be used for joining Types 316,316L stainless steels. It provides high resistance to intergranular corrosion with low carbon weld deposit.

## Notes on usage:

1. Before welding, the base material should be cleaned from oil, rusty, moisture and it should have the proper protection from the wind in welding site.
2. Use 99.8% purity or higher CO<sub>2</sub> shielding gas. Maintain the flow rate not less than 20L/min when wire diameter is 1.2 mm.
3. Keep the product dry, while it is stored or delivered.

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

C	Mn	Si	P				
27	1.25	0.68	0.025	0.006	2.27	11.4	18.6

## Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
558(81)	38

## Welding position:



## Size and recommended parameter range (DC + )

Stick out: 18-25 (mm), flow rate:20-25(l/ min):

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

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