TFW-316LTM

AWS A5.22 E316LT0-4 EN ISO 17633-A-T 19 12 3 L R M21 3 JIS Z 3323 TS 316L-F M2 1 0

Characteristics and Applications:

TFW-316LTM is designed for flat position welding by gas shield of mix gas (75~80% Argon and 25~20% CO₂) 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, 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 mix gas (75~80% Argon and 25~20% CO₂).
- 3. Keep the product dry, while it is stored or delivered.

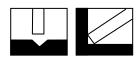
Typical chemical composition of weld metal (wt%):

С	Mn	Si	Р	S	Мо	Ni	Cr
0.024	1.48	0.68	0.025	0.007	2.79	12.18	18.61

Typical mechanical properties of weld metal:

Tensile strength	Elongation		
MPa(ksi)	%		
576(84)	37		

Welding position:



Size and recommended parameter range (DC +) Stick out: 18-25 (mm), flow rate:20-25(I/min):

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

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