# 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% CO<sub>2</sub>) 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% CO<sub>2</sub>).
- 3. Keep the product dry, while it is stored or delivered.

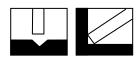
#### Typical chemical composition of weld metal (wt%):

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		

The information contained or otherwise referenced herein is presented only as "typical" without organize or warranty, and Tien Tai Electrode, Co., J. 1d. expressive disclaims and liability, incurred from any reliance thereon. Typical liability contained When welded and lested in accordance with AWS; specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.

