

TFW-317L

AWS A5.22 E317LT1-1
JIS Z 3323 TS 317L-F C 1 1

Characteristics and Applications:

TFW-317L is designed for 100% CO₂ gas shielding and all-position welding wire. It is used for joining types of stainless steels such as 317, 317L, 316, 316L, 316LN, CF-8M and CF-3M. The weld metal exhibits excellent performance of pitting inter-granular corrosion resistance. Common applications include offshore fabrication, chemical tankers as well as petro-chemical, pulp and paper industries.

Notes on usage:

1. Clean up the contaminations on the base metal.
2. Use 99.8% or higher purity CO₂ as shielding gas.
3. Keep the product dry, while it is stored or delivered.

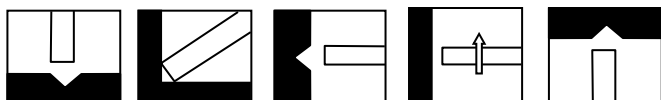
Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Ni	Cr	Mo
0.027	1.32	0.59	0.028	0.007	13.14	19.20	3.57

Typical mechanical properties of weld metal:

Tensile strength MPa(ksi)	Elongation %
620(90)	34

Welding position:



Sizes and recommended parameter range (DC +):

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

Diameter (mm)	1.2
Position	
F, H	140A-220A/23V-33V
V-UP, OH	120A-200A/24V-30V

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