

TFW-308LP

AWS A5.22 E308LT1-4
EN ISO 17633-A T 19 9 L P M21 1

Characteristics and Applications:

TFW-308LP is designed for all position welding by gas shield of mix gas (75~80% Argon and 25~20% CO₂). It features excellent slag detachability. An austenitic stainless steel deposit can be used for joining common austenitic steels such as Types 304,304L, 321, CF-8, and CF-3. It provides good resistance to intergranular corrosion.

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).
3. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
AWS	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	18.0-21.0	9.0-11.0	≤ 0.75	≤ 0.75
EN ISO	≤ 0.04	≤ 2.0	≤ 1.2	≤ 0.030	≤ 0.025	18.0-21.0	9.0-11.0	≤ 0.3	≤ 0.5
Typical value	0.025	1.62	0.45	0.022	0.009	20.67	9.33	0.08	0.11

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	-	≥ 520(75)	≥ 30
EN ISO	≥ 320(46)	≥ 510(74)	≥ 30
Typical value	455(66)	582(84)	40

Welding position:



Sizes and recommended parameter range (DC<+>)

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

Position	Diameter (mm)	1.2
1F, HF		130A-220A/24V-33V
H		140A-180A/25V-29V
V-UP		130A-180A/24V-29V
V-down		150A-180A/25V-29V
OH		150A-180A/25V-29V

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested 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.