

# TFW-308LB

AWS A5.22 E308LT1-1  
EN ISO 17633-A-T 19 9 L P C 1  
JIS Z 3323 TS308L-F C 1

## Characteristics and Applications:

TFW-308LB is a gas shielded flux cored wire suitable for ultra-low temperature applications. The weld metal has low carbon content and contains a proper amount of ferrite in the austenitic structure, it has superior welding performance with good crack resistance and high corrosion resistance. No require post weld heat treated and can be used for welding corrosion-resistant containers. It is suitable for welding stainless steel materials, such as 304, 304L, 321, CF-8 and CF-3 in petrochemical industry, pressure vessels and food machinery.

## 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 99.8% purity or higher CO<sub>2</sub> shielding gas.
3. Keep the product dry, while it is stored or delivered.

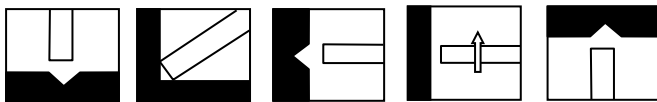
## Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cr	Ni
AWS	≤ 0.04	0.5-2.4	≤ 1.0	≤ 0.04	≤ 0.03	18.0-21.0	9.0-11.0
EN ISO	≤ 0.04	≤ 2.0	≤ 1.2	≤ 0.030	≤ 0.025	18.0-21.0	9.0-11.0
Typical value	0.026	1.40	0.50	0.023	0.008	19.50	9.80

## Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -196°C(-320°F)
AWS	≥ 520(75)	≥ 30	-
EN ISO	≥ 510(74)	≥ 30	-
Typical value	565(82)	40	38(28)

## Welding position:



## Sizes and recommended operating range (DC <+>):

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

Position	Diameter (mm)	1.2	1.6
	F, HF		150A-240A / 26V-32V
H		140A-240A / 25V-32V	200A-300A / 27V-35V
V-UP		130A-160A / 24V-28V	160A-200A / 25V-28V
OH		150A-180A / 25V-28V	-

\* 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.