

# TFW-316LT

AWS A5.22 E316LT0-1  
EN ISO 17633-B-TS 316L-F C1 3  
JIS Z 3323 TS316L-F C 0

## Characteristics and Applications:

TFW-316LT is designed for flat position welding by gas shield of 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, the base material should be cleaned from oil, rusty, moisture and it should have the proper protection from the wind in welding site.
2. Use 99.8% purity or higher CO<sub>2</sub> shielding gas. Maintain the flow rate not less than 20L/min when wire diameter is 1.2 mm.
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	17.0-20.0	11.0-14.0	2.0-3.0	≤ 0.75
EN ISO	≤ 0.04	≤ 2.0	≤ 1.2	≤ 0.030	≤ 0.025	17.0-20.0	11.0-13.0	2.5-0.3	≤ 0.5
Typical value	0.027	1.25	0.68	0.025	0.006	18.6	11.4	2.27	0.05

## Typical mechanical properties of weld metal:

	Tensile strength MPa(ksi)	Elongation %
AWS	≥ 480(70)	≥ 30
EN ISO	≥ 510(74)	≥ 25
Typical value	558(81)	38

## Welding position:



## Size and recommended parameter range (DC<+>)

Stick out: 18-25 (mm), flow rate:20-25(l/min):

Position	Diameter (mm)	1.2	1.6
	F, HF		150A-240A/25V-32V

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