

# TFW-308H

JIS Z 3323 TS308H-FC1  
AWS A5.22 E308HT1-1

## Characteristics and Applications:

TFW-308H is special for 100% CO<sub>2</sub> gas and all-position welding. The weld bead has very excellent slag release. An 19Cr-9Ni austenitic stainless steel deposited that can be used for joining 18Cr-8Ni austenitic steels such as AISI304, AISI301, 302, SUS304H. It provides good resistance to inter-granular corrosion and has higher tensile strength than TFW-308L. It can also be used as an intermediate layer for hard facing.

## Notes on Usage:

1. Before welding, the base material should be cleaned from oil, rusty, moisture and the welding place should have the proper protection from the wind.
2. Use 100% purity or higher CO<sub>2</sub> shielding gas. Maintain the flow rate not less than 20L/min when wire diameter is 1.2 or 1.6 mm.
3. Trailer Shield is required to ensure the weld pool completely shielded until solidification is complete and no porosity problem.
4. Keep dry while in storage and delivery.

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

| C    | Mn   | Si   | P     | S     | Cr    | Ni   | Mo   | Cu   |
|------|------|------|-------|-------|-------|------|------|------|
| 0.06 | 1.64 | 0.50 | 0.028 | 0.009 | 19.52 | 9.92 | 0.10 | 0.10 |

## Typical mechanical properties of weld metal

| TS (MPa) (kgf/mm <sup>2</sup> ) | EL % |
|---------------------------------|------|
| 580(59.4)                       | 41   |

## Welding position



## Sizes and recommended current range (DC <+>)

| Diameter (mm)     | 1.2     |       | 1.6     |       |
|-------------------|---------|-------|---------|-------|
|                   | A       | V     | A       | V     |
| Welding condition |         |       |         |       |
| F、HF              | 140-220 | 23-33 | 200-300 | 27-32 |
| V-UP、OH           | 120-200 | 24-30 | -       | -     |

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