

TFW-308L

JIS Z 3323 TS308L-FC1
AWS A5.22 E308LT1-1
EN 12073 T 19 9 L P C 1

Characteristics and Applications:

TFW-308L is designed for 100% CO₂ gas shielding and all-position welding. It exhibits very excellent slag detachability. And almost spatter-free operating features can be used for joining of austenitic steels such as Types 304, 304L, 321, CF-8, and CF-3. It also provides better inter-granular corrosion resistance due to a low carbon weld deposit.

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 99.8% purity or higher CO₂ shielding gas. Maintain the flow rate not less than 20L/min when wire diameter is 1.2 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	Si	P	S	Mo	Mn	Ni	Cr	Cu
0.029	0.56	0.025	0.008	0.06	1.63	9.93	19.50	0.08

Typical mechanical properties of weld metal

TS (MPa) (kgf/mm ²)	EL %	IV -196°C J(kgf-m)
561(57)	43	39

Welding position



Sizes and recommended current range (DC <+>)

Diameter (mm)	1.2	
Welding condition	A	V
F、HF	130-220	24-33
H	140-180	25-29
V-UP	130-160	24-28
OH	150-180	25-29

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Tien Tai 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 Tien Tai Electrode Co., Ltd.