

TFW-309MoL

JIS Z 3323 TS309LMo-FC1
AWS A5.22 E309LMoT1-1
EN 12073 T 23 12 2 L P C 2

Characteristics and Applications:

TFW-309MoL is a modified type of TFW-309L with the addition of molybdenum. It is suitable for joining stainless steels to unalloyed steels. The addition of molybdenum enhances creep strength and improves corrosion resistance.

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% or higher purity CO₂ as shielding gas. Maintain the flow rate no under than 20L/min when wire diameter is 1.2 or 1.6mm.
3. Trailer Shield is required to ensure the weld pool completely shielded until solidification is complete and no porosity problem.

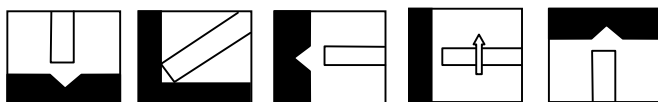
Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Cr	Ni	Cu	Mo
0.025	1.50	0.57	0.023	0.010	22.93	12.70	0.07	2.35

Typical mechanical properties of weld metal

TS (MPa) (kgf/mm ²)	EL %	CVN 0°C J(kgf-m)
685	33	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

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