

# TFW-317L

AWS A5.22 E317LT1-1  
JIS Z 3323 TS317L-FC1

## Characteristics and Applications:

TFW-317L is designed for 100% CO<sub>2</sub> gas shielding and all-position welding wire. It is used for joining Types of stainless steels such as 317, 317L, 316, 316L, 316LN, CF-8M and CF-3M. The weld metal exhibits excellent performance of pitting inter-granular corrosion resistance. Common applications include offshore fabrication, chemical tankers as well as petro-chemical, pulp and paper industries.

## Notes on Usage:

1. Clean up the contaminations on the base metal.
2. Use 99.8% or higher purity CO<sub>2</sub> as shielding gas. Maintain the flow rate not under than 20L/min while 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.

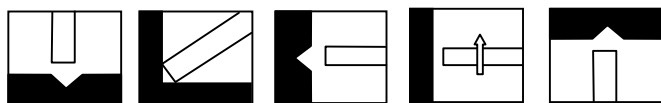
## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Cr	Mo
0.03	1.34	0.65	0.020	0.005	13.50	18.26	3.19

## Typical mechanical properties of weld metal

TS (MPa)	EL %	CVN -0°C J
660	34	59

## 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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