

TFW-317L

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

Characteristics and Applications:

TFW-317L is designed for 100% CO₂ 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 CO₂ 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.

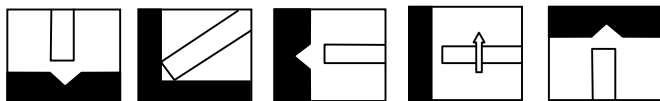
Typical chemical composition of weld metal (wt%)

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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