

TGFA-308H/TGFA-308L/ TGFA-316L/TGFA-309L/ TGFA-309MoL/TGFA-317L/ TGFA-347

TGFA-308L
AWS A5.22 R308LT1-5 / JIS Z 3323 TS308L-R1

TGFA-316L
AWS A5.22 R316LT1-5 / JIS Z 3323 TS316L-R1

TGFA-309L
AWS A5.22 R309LT1-5 / JIS Z 3323 TS309L-R1

TGFA-347
AWS A5.22 R347T1-5 / JIS Z 3323 TS347-R1

Characteristics and Applications:

TGFA series is a flux cored wire of stainless steel for TIG welding used on first layer for butt joint. Good bead soundness without back shielding can be obtained.

Notes on Usage :

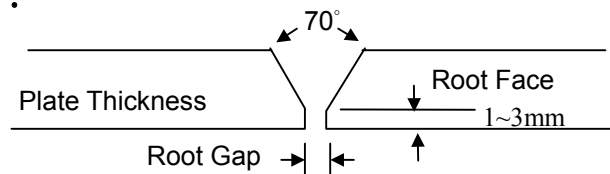
1. 100%Ar shielding gas is recommended.
2. In order to have beautiful back bead appearance, the key hole formation during welding is necessary. The proper key hole size is recommended.
3. High pitch and little by little feeding of a filler rod is a must in order to melt it adequately.
4. Keep away from moisture during storage and transportation.

Typical Chemical Composition of Weld Metal (wt%) : (Shielding gas : 100%Ar)

Product Name	C	Si	Mn	P	S	Ni	Cr	Mo	Nb
TGFA-308H	0.059	0.61	1.42	0.022	0.009	10.52	20.51	-	-
TGFA-308L	0.027	0.60	1.40	0.022	0.008	10.63	20.50	-	-
TGFA-316L	0.027	0.52	1.35	0.023	0.007	12.25	18.56	2.30	-
TGFA-309L	0.022	0.59	1.45	0.024	0.009	12.39	23.26	-	-
TGFA-309MoL	0.025	0.60	1.52	0.024	0.008	13.33	23.55	2.41	-
TGFA-317L	0.024	0.63	1.51	0.023	0.007	13.21	19.03	3.36	-
TGFA-347	0.024	0.59	1.53	0.024	0.006	10.22	19.22	-	0.63

Reference Welding Conditions :

Groove Preparation



Package :

Diameter & Length (mm) : 2.2 x 915

Sizes and Recommended Current Range :

Plate Thickness mm	Root Gap mm	Current A	Shielding Gas:Ar:10~15L/min		Power DCSP
			Size(mm)		
2~4	2.0	80~90	Dia.	Length	
5~9	2.5	90~105	2.2	915	
>10	3.0	90~110			

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