

TGFA-308L/TGFA-316L / TGFA-309L/TGFA-347L

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-347L
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. It provides good bead soundness and does not need back shielding. These wires can also be used on multi-layers welding.

Notes on usage:

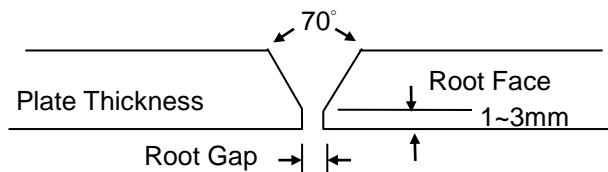
1. 100%Ar shielding gas is recommended.
2. In order to have beautiful back bead appearance, the key hole formation during welding is necessary. The proper key hole size is recommended.
3. High pitch and little by little feeding of a filler rod is a must in order to melt it adequately.
4. Keep the product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

Typical chemical composition of weld metal (wt%) :

Product Name	C	Mn	Si	P	S	Ni	Cr	Mo	Nb
TGFA-308L	0.02	1.40	0.4	0.022	0.008	10.30	20.20	-	-
TGFA-316L	0.027	1.35	0.52	0.023	0.007	12.50	18.56	2.30	-
TGFA-309L	0.022	1.45	0.35	0.024	0.009	13.50	23.26	-	-
TGFA-347L	0.024	1.53	0.5	0.024	0.006	10.22	20.00	-	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)	Power DCSP
2~4	2.0	80~90	DC-
5~9	2.5	90~105	
>10	3.0	90~110	

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