

GFW AP Series

● Applications and Characteristics

AP series wire is correspond to JIS TSXXX-FC1, AWS EXXXT1-1 type wire and suitable for positional welding with proper slag viscosity. Of course AP Series wires are applicable in flat position and horizontal position.

Shielding gas is limited to CO₂ gas only.

● Typical Chemical Composition of All Weld Metal (%)

Trade Name	Position	Chemical Composition (%)								
		C	Si	Mn	P	S	Ni	Cr	Mo	Cu
GFW308LAP	Flat	0.024	0.42	1.48	0.026	0.004	10.06	19.71	0.02	0.02
	Vertical Upward	0.027	0.46	1.49	0.027	0.005	10.22	19.21	0.02	0.01
GFW309LAP	Flat	0.023	0.42	1.37	0.026	0.007	12.34	23.47	0.01	0.03
	Vertical Upward	0.030	0.39	1.35	0.025	0.006	12.56	23.21	0.01	0.02
GFW316LAP	Flat	0.023	0.42	1.46	0.028	0.004	12.61	19.18	2.35	0.03
	Vertical Upward	0.032	0.44	1.42	0.026	0.005	12.51	19.10	2.27	0.03
GFW309MoLAP	Flat	0.027	0.36	1.52	0.027	0.005	12.84	22.89	2.37	0.05
	Vertical Upward	0.034	0.39	1.63	0.026	0.005	12.81	22.76	2.34	0.03

● Typical Mechanical Properties of All Weld Metal (Flat position)

Trade Name	Tensile Strength (MPa)	5D Elongation (%)
GFW308LAP	560	39.8
GFW309LAP	584	36.2
GFW316LAP	564	37.4
GFW309MoLAP	593	33.6

● Recommended Welding Conditions

Position	Welding Current (A)	Welding Voltage (V)	Welding Speed (mm/min)
Flat	170~200	28~32	200~400
Horizontal	170~200	28~32	200~400
Vertical Upward	130~170	24~26	80~200
Vertical Downward	180~200	26~28	400~600
Overhead	140~170	24~26	250~450

Wire Extension ; 15~25mm

TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

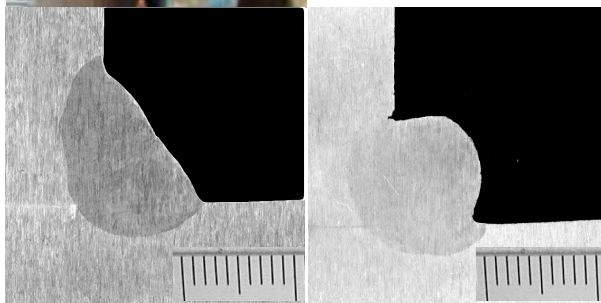
● Bead Appearances in Vertical Upward Welding

GFW308LAP

GFW308L



Bead appearance



Cross sectional
shape

Welding Conditions:

Welding current: 150A

Welding Voltage: 25V

Welding speed: 10cm/min

Weaving width: 8mm