

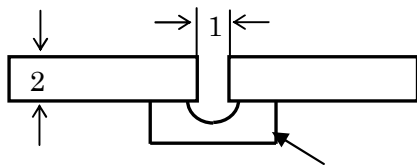
0.9mm GFW Wires

● Applications and Characteristics

1. Suitable for welding of plate with 1.5 mm to 2.5 mm thickness which are impossible to weld with 1.2 mm wire.
2. Applicable in flat, horizontal, or vertical position.
3. Good wettability of weld metal to base metal and smooth beads.
4. Good arc stability.
5. Less spatters and easy removable slag.

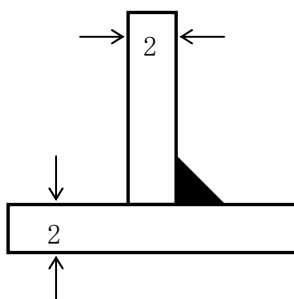
● Typical Welding Conditions

Joint configuration	Welding Current (A)			
	Butt	Lap	Horizontal fillet	Edge
Thickness (mm)				
1.5	80~110 A	80~110 A	80~110 A	70~90 A
2.0	90~130 A	90~120 A	90~120 A	80~100 A
2.5	100~130 A	100~130 A	100~130 A	80~110 A



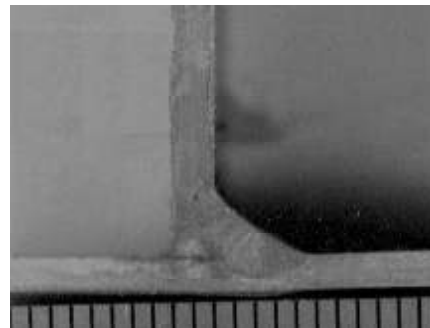
Unit : Copper Backing Plate

Welding current : 100~110A, Voltage : 30~32V, Speed : 60 cm/min



Unit : mm

Welding current : 100A, Voltage : 30V, Speed : 60 cm/min

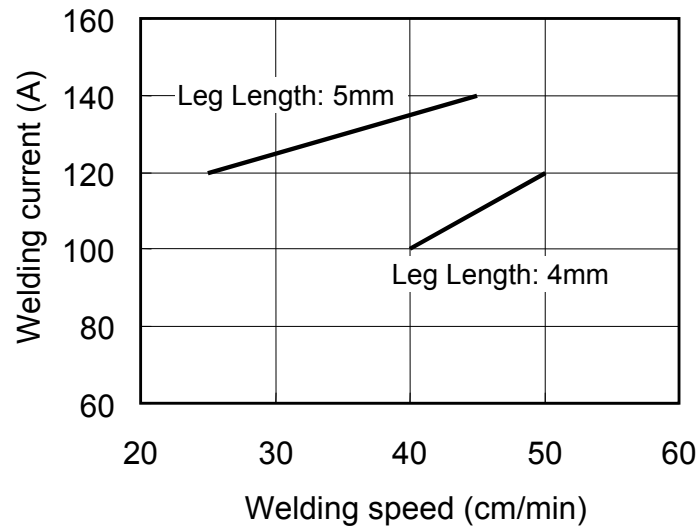


TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

● Welding Conditions & Leg Length of Horizontal Fillet Welding



● Typical Chemical Composition and Mechanical Properties of All Weld Metal

Brand Name	Chemical Composition										Mechanical Properties	
											Tensile Strength (MPa)	5D Elongation (%)
	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb	(%)	
GFW308*	0.046	0.57	1.88	0.021	0.005	9.94	19.82	0.02	0.03	—	583	38.2
GFW308L	0.030	0.60	1.64	0.024	0.006	9.94	19.39	0.02	0.02	—	571	38.4
GFW309*	0.045	0.65	1.71	0.025	0.005	12.64	23.60	0.03	0.03	—	611	36.2
GFW309L	0.031	0.58	1.59	0.025	0.005	12.55	23.68	0.01	0.01	—	601	36.4
GFW316*	0.044	0.66	1.82	0.025	0.005	11.75	19.46	2.41	0.02	—	582	38.0
GFW316L	0.024	0.53	1.65	0.024	0.006	12.50	19.32	2.36	0.04	—	571	34.2
GFW347*	0.040	0.54	1.60	0.023	0.007	10.40	18.90	0.03	0.02	0.60	589	34.2
GFW309MoL	0.030	0.45	1.43	0.027	0.005	12.46	23.57	2.29	0.03	—	584	32.2

*Order made

● Notes on Usage

1. Use 100%CO₂ as shielding gas and control the flow rate at 15L/min. Keep wire extension in 10 mm to 15 mm.
2. Use a direct-current constant-voltage power source
3. Use the exclusive feed roller for 0.8 mm or 0.9 mm wire. Limit the pressure of the feed roller to the lowest level possible for feeding wire.
4. Use the exclusive flexible conduit liner for 0.8 mm or 0.9 mm wire.

TASETO Co., Ltd