

# TASETO Welding Materials

Stainless Steel Electrodes

For Flux Cored Arc Welding

## GFW2307

Applicable Specification  
AWS A5.22 E2307T0-1

### ● Applications and Characteristics

TASETO GFW2307 is used for welding of lean duplex stainless steel such as UNS S32101, S32307.

### ● Notes on Usage

- \* Preheating is not necessary and interpass temperature should be kept under 150°C.
- \* Post weld heat treatment causes severe embrittlement of weld metal.
- \* Use 100%CO<sub>2</sub> as shielding gas.

### ● Chemical Composition of All Weld Metal (%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	N
Typical	0.030	0.70	1.50	0.016	0.002	8.18	25.38	0.46	0.03	0.13

### ● Tensile Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)
Typical	621	780	25.0

### ● Corrosion Resistance of All Weld Metal

\* Typical Corrosion Resistance 0.00032 in/month (0.10 g/m<sup>2</sup>·h)  
(65% Nitric Acid Test)

### ● Sizes Available and Shielding Gas

Size (mm)	Shielding Gas
1.2	CO <sub>2</sub> , 20L/min