TF-250R

Basicity index: 2.7

EN ISO 14174 S A FB 1 55 AC H5

Characteristics and Applications:

TF-250R is a high–basic agglomerated submerged arc flux. It is suitable for using DC+ single, AC single, DC+/AC and AC/AC. It provides excellent weld ability even in narrow groove. good mechanical properties of weld metal can be controlled by using the appropriate wire grade.

With combination of low phosphorous wires (TSW-E22R), the X factors can be controlled under 12ppm.

- Heat treatable and heat resistant low-alloy CrMo steel
- Pressure vessel
- X-factor≦12ppm

Notes on usage:

1. Dry the flux at 300~350℃ for 2~4hrs holding time.
2. Adding proper quantity of new flux with the used one to maintain good quality of weld metal.

Typical chemical composition of weld metal (wt %) :

Wire	EN ISO 24598-A	C	Si	Mn	P	S	Cr	Mo	Cu	X factor
TSW-E22R	S 55 3 FB CrMo1	0.07	0.23	0.90	0.010	0.005	1.20	0.46	0.04	≦ 12ppm

Typical mechanical properties of weld metal:

Wire	AWS A5.23	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Temperature °C(°F)	PWHT
TSW-E22R	F8P2-EB2R-B2R	515(75)	600(87)	28	130(96)	-30(-20)	690℃/1hr

FLUXES & WIRES

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