

TF-666

Basicity index: 1.3

EN ISO 14174 S AAB 1 68 AC H5

Characteristics and Application:

TF-666 is an agglomerated submerged-arc welding flux, and it is specifically designed for fillet welding and, multi-pass butt welding of mild high tensile steels.

When using plates with heavy scales, TF-666 still provides smooth bead appearance and high porosity resistance. It also shows good operability both in single and multi-wire systems.

It is suitable for welding of steel structures (H-Beam, Box), pressure vessel and shipbuilding etc.

Notes on usages :

1. Flux should be used immediately after taking out from can Damp. Flux should be re-dried at 300~350°C for 1~2hr 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 14171-A	C	Si	Mn	P	S
TSW-12KM	S 42 3 AB S2Si	0.058	0.43	1.45	0.029	0.016
SubCor M13K	-	0.06	0.30	1.46	0.027	0.010

Typical mechanical properties of weld metal:

Wire	AWS A5.17	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Temperature °C(°F)
TSW-12KM	F7A2 -EM12K	454(66)	533(77)	33	60(44)	-30(-20)
SubCor M13K	F7A6-EC1	452(66)	525(76)	35	55(41)	-51(-60)

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