

TF-R85

An agglomerated flux for SAW Hard-facing

Characteristics and Applications:

TF-R85 is a basic agglomerated flux for SAW. During welding, it won't result in any significant changes composition of weld bead and thus the arc length by changing arc voltage. TF-R85 is very suitable for using metal cored wire for hard-facing applications such as TWH- 12-S, 17-S, 31-S, 52-S, and TWS- 410-S, 410NiMo-S, 420-S, 420Mo-S, RolClad-19-S, 30S, 80S.. etc. The weld bead has good appearance and excellent slag detachment in high inter-pass temperature (>400°C). as well as low impurities. It is also provide lower hot crack susceptibility.

Notes on Usage:

1. Dry flux at 300~350°C for one hour if there is any concern about moisture pick-up while opening the pack.
2. Add reasonable amount of new flux when recycled flux is used.

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