

TFS-303

EN ISO 14174 S F CS 2 DC

Characteristics and Applications:

TFS-303 is a fused type of flux for various applications. It is designed primarily for SAW of 5%, 9%Ni alloys and joining of dissimilar base metals. You can produce good results when weld pipes and steels in combination with appropriate TW-17 wire electrodes.

- 5% & 9%Ni alloys
- Pipe or plate join

Notes on usage:

1. Drying the flux at 150°C~300°C for 1hr if moisture pick-up of flux is suspected.
2. Adding proper quantity of new flux with the used one to maintain good quality of weld metal.
3. While using TW-17 as combination, keep the inter-pass temperature under 100°C.

Typical chemical composition of weld metal (wt %) :

Wire	C	Mn	Si	P	S	Ni	Cr	Mo	V	Co	W	Fe
TW-17 (ERNiCrMo-4)	0.015	0.40	0.43	0.02	0.004	57.8	15.4	15.5	0.13	0.05	3.40	5.70

Typical mechanical properties of weld metal:

Wire	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -196°C (-320°F)
TW-17	470(68)	680(99)	40	75(55)

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