

TFS-340

Basicity : 2.3

EN ISO 14174 SA FB 2 55 45 AC

Characteristics and applications:

TFS-340 is a basic agglomerated flux for SAW of Ni-alloys. It is designed primarily for SAW of 825, 5%Ni & 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.

- 825, 5%Ni & 9%Ni alloys
- Cryogenic applications
- Pipe or plate join

Notes on usage:

1. The flux must be re-dried at a temperature of 300~350°C for 1~2hr holding time when it is affected by moisture pick-up.
2. While using TW-17 as combination, keep the inter-pass temperature under 150°C.

Typical chemical composition of weld metal (wt%) :

Wire	C	Mn	Si	P	S	Ni	Cr	Mo	V	Co	W	Fe	Ti	Al	Nb
TW-17 (ERNiCrMo-4)	0.02	0.6	0.26	0.017	0.006	57.8	15.0	15.1	0.03	0.07	3.78	7.23	0.03	0.03	0.02

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)	PWHT
TW-17	490(71)	718(104)	40	85(63)	AW

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