

TF-565

Basicity index: 1.6

EN ISO 14174 S AAB 1 68 AC H5

Characteristics and Applications:

TF-565 is an agglomerated aluminates basic flux, with little weld metal alloy pick-up of Mn and Si. Suitable for welding non-and low alloy steels with single and multiple wires application. Designed for two-run or multiple layers with both AC and DC technique. Has excellent slag detachability and good operation performance. Good mechanical properties at low temperatures can be achieved if it is combined with appropriate wire. It is suitable to be applied in following industries.

- Shipbuilding
- Boiler and Pressure Vessel
- Pipemill up to API-5L-X70
- Low alloy and High Tensile/Strength Steel Structural Fabrication
- Bridge Fabrication

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. Adding a certain amount of new flux with 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	0.06	0.4	1.7	0.03	0.010
SubCor M13K	-	0.05	0.27	1.6	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	460(67)	530(77)	30	65(48)	-30(-20)
	F7A4-EM12K				40(30)	-40(-40)
SubCor M13K	F7A6-EC1	450(65)	515(75)	34	50(37)	-51(-60)

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.