

TFS-350

EN ISO 14174 SA FB 2

Characteristics and Applications:

TFS-350 is a neutral, agglomerated flux designed for wire welding with TW-61. Typical applications are overlaying and multi-pass welding at 1G position. TFS-350 exhibits very smooth, tight-rippled weld bead appearance and excellent wetting action.

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. Re-circulation of flux should be mixed with twice its volume of new flux prior to further use.
3. We recommend using heated hoppers for storage of flux in production.

Typical chemical composition of weld metal (wt %) :

Wire	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	Fe	Nb+Ta
TW-61 (ERNiCrMo-3)	0.021	0.37	0.42	0.01	0.005	64.7	21.6	8.3	0.008	0.84	3.34

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-61	477(69)	726(105)	45	96 (71)

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