

TF-218

Basicity index: 2.2

EN ISO 14174 S A FB 1 55 AC H5

Characteristics and Applications:

TF-218 is a basic agglomerated submerged-arc welding flux that is recommended for high productive welding procedures in unalloyed and fine-grained low alloy steels requiring good quality welds with high toughness properties at low temperatures. TF-218 is established for welding wind towers and providing a high level of consistency and mechanical property performance. The flux promotes a very stable arc which providing excellent slag detachment in narrow gap welds. The weld is of a uniform even profile with regular fine ripple formation and smooth toe blending. TF-218 is suitable for use with DC+ or AC and is ideal for single wire, twin wire, tandem arc.

Notes on usage:

1. Flux exposed to atmosphere for an excess period must be re-baked at 300~350°C for 1~2hrs holding time.
2. Re-circulation of flux should be limited to three cycles. After this, the 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	EN ISO 14171-A	C	Mn	Si	P	S
TSW-12KH	S 46 6 FB S3Si	0.07	1.51	0.30	0.014	0.005
TSW-12KM	S 38 5 FB S2Si	0.06	1.16	0.26	0.018	0.005

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-12KH	F7A8-EH12K	498(72)	575(84)	30	100(74)	-62(-80)
TSW-12KM	F7A6-EM12K	448(46)	532(54)	33	186(137)	-51(-60)

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