# TF-250R

**Basicity index: 2.7**

EN ISO 14174 S A FB 1 55 AC H5

## Characteristics and Applications:

TF-250R is a high–basic agglomerated submerged arc flux. It is suitable for using DC+ single, AC single, DC+/AC and AC/AC. It provides excellent weld ability even in narrow groove. good mechanical properties of weld metal can be controlled by using the appropriate wire grade.

With combination of low phosphorous wires (TSW-E22R), the X factors can be controlled under 12ppm.

- Heat treatable and heat resistant low-alloy CrMo steel
- Pressure vessel
- X-factor≦12ppm

## Notes on usage:

1. Dry the flux at 300~350℃ for 1~2hrs holding time.
2. Adding proper quantity of new flux with the used one to maintain good quality of weld metal.

## Typical chemical composition of weld metal (wt %) :

| Wire | EN ISO 24598-A | C | Si | Mn | P | S | Cr | Mo | Cu | X factor |
|---|---|---|---|---|---|---|---|---|---|---|
| TSW-E22R | S 55 3 FB CrMo1 | 0.07 | 0.23 | 0.90 | 0.010 | 0.005 | 1.20 | 0.46 | 0.04 | ≦ 12ppm |

## Typical mechanical properties of weld metal:

| Wire | AWS A5.23 | Yield strength MPa(ksi) | Tensile strength MPa(ksi) | Elongation % | Charpy V-Notch J (ft-lbf) | Temperature °C(°F) | PWHT |
|---|---|---|---|---|---|---|---|
| TSW-E22R | F8P2-EB2R-B2R | 515(75) | 600(87) | 28 | 130(96) | -30(-20) | 690℃/1hr |

FLUXES & WIRES



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