

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 \leq 12ppm

Notes on usage:

1. Dry the flux at 300~350°C 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	\leq 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°C/1hr

* 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.