TFS-300NB

Basicity index: 2.7

EN ISO 14174 S A FB 2 DC

Characteristics and Applications:

TFS-300NB is a neutral bonded flux, which has good weldability, excellent slag removal and smooth bead appearance. Its important characteristics include low C, P and S contents in the flux. Some alloys are suitably added to maintain the stability of the alloy content in weld metal. It performs a very sophisticated mechanical properties and corrosion resistibility. At -196℃ represents the better impact value.

- Stainless308, 308L, 316 and 316L butt join.
- Pressure vessel

Notes on usage:

1. Use low heat input to keep the corrosion resistibility and mechanical properties on heat-affected zone unchanged.
2. Bake at 300~350°C for 1~2hr before use.
3. Add reasonable new flux when recycle the used flux so as to maintain good welding quality.

Typical chemical composition of weld metal (wt %):

Wire	C	Mn	Si	P	S	Cr	Ni	Mo
TW-308L	0.028	1.45	0.53	0.021	0.012	19.0	10.3	-
TW-316L	0.034	1.287	0.56	0.030	0.006	17.7	11.3	2.0

Typical mechanical properties of weld metal:

Wire	AWS A5.39	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -196℃(-320°F)
TW-308L	F75A32-ER308L/308L	565(82)	42	50(37)
TW-316L	F75A32-ER316L/316L	547(79)	40	60(44)

FLUXES & WIRES

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