

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 2~4hrs 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(PWHT
TSW-E22R	F8P2-EB2R-B2R	515(75)	600(87)	28	130(96)	-30(-20)	690 /1hr

... or warranty, and Tientai Electrode Co., Ltd. expressly disclaims any liability
... in AWS specification. Other tests and procedures may produce different results.
... y Tientai Electrode Co., Ltd.

The information contained or otherwise referenced herein is presented only as "typical" without guarantee
inferred from any reliance thereon. Typical data is obtained when welded and tested in accordance with
No data is to be construed as recommendation for any welding condition or technique not controlled by

... Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan
TEL: 886-6-2663721 / FAX: 886-6-2664301

AN ILLINOIS TOOL WORKS COMPANY

... TIENTAI
E-mail: twrad@twweld.com
http://www.tientai.com

No. 6

1902