

# TF-R85

An agglomerated flux for SAW Hard-facing

## Characteristics and Applications:

TF-R85 is a basic agglomerated flux for SAW. During welding, it won't result in any significant changes composition of weld bead and thus the arc length by changing arc voltage. TF-R85 is very suitable for using metal cored wire for hard-facing applications such as TWH- 12-S, 17-S, 31-S, 52-S, and TWS- 410-S, 410NiMo-S, 420-S, 420Mo-S, RoClad-19-S, 30S, 80S.. etc. The weld bead has good appearance and excellent slag detachment in high inter-pass temperature (>400°C). as well as low impurities. It is also provide lower hot crack susceptibility.

## Notes on Usage:

- 1.Dry flux at 300~350 W for one hour if there is any concern about moisture pick-up while opening the pack.
- 2.Add reasonable amount of new flux when recycled flux is used.

FLUX

Electrode Co., Ltd. expressly disclaims any liability  
for any and all damages, including consequential damages, arising from the use of this product.

\* 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 for any and all damages, including consequential damages, arising from the use of this product. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.

No. 6, Kaifa 4th Rd., Bende Dist., Tainan City 717, Taiwan

E-mail: [twtrad@itwweid.com](mailto:twtrad@itwweid.com)  
<http://www.tientai.com>