

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 250~350°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	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -196 (-320)
TW-308L	565(82)	42	50(37)
TW-316L	547(79)	40	60(44)

This information contains no other reference to the origin of the product, and is not intended to be construed as a recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.