

# TFS-330CR

Basicity 1.8

EN ISO 14174 SA AF 2 DC

## Characteristics and Applications:

TFS-330CR is a Cr-compensate agglomerate SAW flux. Used for AISI 300 series stainless steel. The chromium alloying effect from TFS-330CR compensates for the chromium losses in the arc during welding.

- 300 series stainless steel
- Cr-compensate
- Wire cladding, dissimilar metal join
- Applied to chemical plants, offshore, pressure vessels, storage tanks, power generation constructions, etc.

## Notes on usage:

Flux exposed to atmosphere for an excess period must be re-baked at 300-350 °C for 1~2hr holding time.

## Typical chemical composition of weld metal (wt %) :

Wire	C	Mn	Si	P	S	Mo	Cr	Ni	Cu	Nb
TW-308L	0.03	1.28	0.61	0.021	0.008	0.07	20.51	9.52	0.119	--
TW-309L	0.02	1.28	0.63	0.022	0.007	0.07	23.16	13.42	0.103	--
TW-316L	0.03	1.26	0.64	0.027	0.007	2.12	19.02	11.72	0.119	--
TW-347	0.03	1.81	0.62	0.026	0.007	0.12	20.27	9.62	0.135	0.79

## Typical mechanical properties of weld metal:

Wire	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Temperature °C( )
TW-308L	417(43)	628(64)	42	67(6.8)	-196
TW-309L	424(43)	576(59)	36	48(4.9)	-196
TW-316L	388(40)	556(57)	40	45(4.6)	-196
TW-347	465(47)	634(65)	38	48(4.9)	-110

FLUXES & WIRES

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