TF-350CMV

Basicity index: 2.8

EN ISO 14174 S A FB 1 55 AC H5

Characteristics and Applications:

TF-350CMV is a high–basic agglomerated submerged arc flux. It's designed for the welding of creep resistant steel, 2.25Cr-1Mo-0.25V, with high toughness at low temperature and high purity of weld metal. It is suitable for using DC+ single, AC single, DC+/AC and AC/AC. It provides excellent weld ability even in narrow groove. Due to its neutral behavior, you can use the appropriate wire grade to control good mechanical properties of weld metal.

Submerged arc metal core wire, SubCor, provide higher deposition rates using the same flux when compared to the solid wire counterparts at the same amperage and electrical stickout. Penetration patterns tend to be broader in width than similar solid electrodes. Adjustments in parameters allow composite electrodes to bridge moderate gaps more easily than the deep, narrow penetration of solid wire.

With combination of low phosphorous wires, the X and J factors can be controlled to satisfy the step cooling requirement.

- Heat treatable and heat resistant low-alloy CrMoV steel.
- Pressure vessel

Notes on usage:

1. Dry the flux at 300~350℃ for 2~4hr holding time.

Typical chemical composition of weld metal (wt %):

Wire	EN ISO 24598-A	C	Si	Mn	P	S	Cr	Mo	V	Cu	Note
TSW-E23V	S 62 3 FB CrMoV1	0.11	0.13	1.21	0.009	0.004	2.22	0.95	0.26	0.048	X<12ppm
SubCor B3V	-	0.10	0.16	1.43	0.010	0.005	2.18	1.15	0.26	0.013	X<15ppm

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(°F)	PWHT
TSW-E23V	F9P2-E24-GR	606(88)	707(103)	25	97(72)	-30(-20)	710℃*8hr
SubCor B3V	F9P2-ECG-GR	598(87)	697(101)	24	95(70)	-30(-20)	710℃*8hr

FLUXES & WIRES

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