

TF-81

(SAW 硬面用鐸藥)

特性與用途：

TF-81 是一種中性燒結型潛弧鐸藥，鐸接期間不會因電壓改變，造成鐸道成份改變與減少。因此 TF-81 可適用 搭配 TWH-12-S、17-S、31-S、45-S 和 TWS-410-S、410NiMo-S、420-S 等包藥鐸線使用。

注意事項：

- (1)開封後的鐸藥，如受潮須烘乾 300~350°C 烘乾 1~2 小時。
- (2)若使用回收之鐸藥時，須添加新鐸藥以確保品質。

鐸道化學成份之一例(wt%)：

鐸線	C	Si	Mn	Cr	Mo	Ni	V	Nb	W	Co	Cu
TWH-12-S	0.2	0.5	1.5	6.0	1.2	-	0.2		0.9	-	-
TWH-17-S	0.05	0.5	2.3	2.0	0.5	-	-	-	-	-	-
TWH-31-S	0.1	0.4	2.8	0.1	0.5	-	-	-	-	-	-
TWS-420-S	0.2	0.4	1.0	12.5	-	-	-	-	-	-	-
TWH-52-S	0.2	0.5	1.8	3.2	2.0	3.0	0.5	-	-	-	-
TWS-410NiMo-S	0.03	0.1	0.3	12.0	1.0	4.0	-	-	-	-	-
TWS-420Mo-S	0.3	0.5	1.0	11.0	1.5	-	0.3	0.15	-	1.0	-
TWS-423-S	0.13	0.4	1.1	13.5	1.0	2.5	0.2	0.2	-	-	-
TWS-430-S	0.01	0.3	1.3	16	0.4	3	-	-	-	-	0.3
RoIclad-19-S	0.05	0.5	1.5	1.0	2.0	-	-	-	-	-	-
RoIclad-80-S	0.9	0.5	0.4	8.0	3.0	-	0.5	5.0	1.20	-	-

鐸接參數建議：(DC+)

鐸線	硬度 (AW)
TWH-12-S	47-53
TWH-17-S	34-37
TWH-31-S	28-32
TWS-420-S	46~52
TWH-52-S	47~52
TWS-410NiMo-S	32-37
TWS-420Mo-S	52~56
TWS-423-S	43-46
TWS-430-S	31-35
RoIclad-19-S	26~33
RoIclad-80-S	59-62

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