

# 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(°F)
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

\* 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 incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.