

# TF-385

Basicity index: 0.6

EN ISO 14174 S AAR 1 78 AC H5

## Characteristics and Applications:

TF 385 is an agglomerated, low basicity flux with pick up of Mn and Si. It's suitable for welding with single and multiple wire process with AC as well DC. Has excellent bead appearance, resistant against porosity and excellent slag release.

- Shipbuilding
- Structural Steels
- LPG Cylinders

## Notes on usage:

1. The flux must be re-dried at a temperature of 300~350°C for 1~2hr holding time when it is affected by moisture pick-up.
2. Adding proper quantity of new flux with the used one to maintain good quality of weld metal.

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

Wire	EN ISO 14171-A	C	Si	Mn	P	S
TSW-12KM	S 38 0 AR S2Si	0.06	0.7	1.7	0.031	0.01
TSW-12KH	S 42 2 AR S3Si	0.06	0.7	1.8	0.03	0.01

## Typical mechanical properties of weld metal:

Wire	AWS A5.17	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Temperature °C(°F)
TSW-12KM	F7A0-EM12K	480(70)	550(80)	33	40(30)	-20(0)
TSW-12KH	F7A2-EH12K	529(77)	589(85)	30	43(32)	-30(-20)

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