

TFS-330

Basicity : 2.0

EN ISO 14174 S A AF 2 DC

Characteristics and Applications:

TFS-330 is designed for both butt and fillet welding applications. TFS-330 behaves neutrally with regard to carbon content in the filler wire. The metallurgical behavior of the flux in respect to silicon and manganese is also neutral and as a result there is minimal burn out or pick up of these elements. The resultant weld bead is free from slag residue and requires little or no post weld dressing. Grain size according to DIN EN 760 : 2-20.

- For submerged arc welding of the 300 series stainless steels, especially for 347 & 2209
- Applied to chemical plants, offshore, pressure vessels, storage tanks, power generation constructions, etc.

Notes on usage:

1. 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	Others
TW-347	0.04	1.82	0.58	0.03	0.01	0.10	19.0	10.2	0.12	Nb:0.70
TW-2209	0.02	1.20	0.56	0.02	0.01	2.82	21.8	9.0	0.07	N:0.15

Typical mechanical properties of weld metal:

Wire	AWS A5.39	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf)	Temperature °C(°F)
TW-347	F80A15- ER347/347	460(67)	620(90)	36	50(37)	-110(-166)
TW-2209	F100A4- ER2209/2209	591(86)	780(113)	31	74(55)	-40(-40)

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