

TF-565

An agglomerated basic slightly Si and Mn alloying flux for submerged arc welding.

Density: 1.5kg/dm³ approx

Basicity index: 1.6

Classification

AWS A5.17-97: F7A4-EM12K

F8A4- EH14

AWS A5.23-90:F8A2-EG-G

Applications:

TF-565 is specially designed for fillet welding and for single and multipass but welding of mild, medium and high tensile steels.

TF-565 is of aluminate basic type and has for this slag system very high current carrying capacity on both AC and DC and has for a basic slag system very good operability characteristics both in single and multiwire systems. It is possible to achieve the required strength level of the weld metal by selection of suitable alloyed wires since the alloying effect mainly devices from the wire.

Notes on usages :

1. Flux should be used as fast as possible after taking out from can Damp flux should be redried at 350°C for 1 hour.
2. Adding proper quantity of new flux with the used one to maintain good quality of weld metal.

Typical welding metal composition% :

Wire	C	Si	Mn	P	S	Mo
TSW-12KM	0.06	0.3	1.5	0.022	0.008	-
TSW-14H	0.06	0.2	2.0	0.025	0.006	-
TSW-60G	0.06	0.3	1.7	0.025	0.008	0.2

Typical mechanical properties. All weld metal :

Wire	Y.P N/mm ²	T.S N/mm ²	EL %	IV J	Temp. °C
TSW-12KM	441	520	33	70	-29
				40	-40
TSW-14H	490	580	31	40	-40
				40	-40
TSW-60G	560	610	28	50	-29
				50	-29



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