



"WELD WITH THE BEST"

SUBMERGED ARC WELDING FLUX SnFLUX™ TW-223

Codification: AWS: SFA 5.17 F7A4/P4-EM12K, F7A4/P4-EH14, F7A4/P4-EH10K
AWS: SFA 5.23 F8A2/P2-EA2-A2

Characteristics & Applications:

SnFLUX TW-223 is an basic type flux designed for achieving high-quality welds in various welding applications, including high-speed longitudinal welding, Its smooth bead formation, ease of slag removal, and enhanced current carrying capacity make it a valuable tool for welders looking to achieve strong and aesthetically pleasing welds. the flux alloys some Si and Mn to the weld metal and works equally well on DC and AC current.

SnFLUX TW-223 is suitable for carbon and low alloy steel, pressure vessel grade steels (EN 10028-2), pipes conforming to X-42 to X-70 grade of API 5L, Grade 1/2 /3 of ASTM A252, SA 516 Grade 70, Grade A/B of A53 & A523 specification, etc.

Chemical Composition of All-Weld Metal, WT% (Typical):

Wire Grade	C	Mn	Si	S	P	Mo
SFA 5.17 EM-12K	0.070	1.25	0.28	0.020	0.026	-
SFA 5.17 EH-14	0.070	1.80	0.35	0.015	0.028	-
SFA 5.17 EH-10K	0.060	1.60	0.40	0.010	0.022	-
SFA 5.23 EA-2	0.080	1.30	0.40	0.018	0.022	0.48

Mechanical Properties of All-Weld Metal (Typical):

Wire Grade	UTS Mpa	YS (Mpa)	EL (L=4d) %	CVN Impact, J at	
				-29°C	-40°C
SFA 5.17 EM-12K (As-Welded)	440	530	28	48	34
SFA 5.17 EM-12K (SR 620°C/1hr.)	410	500	30	58	40
SFA 5.17 EH-14 (As-welded)	430	540	26	60	40
SFA 5.17 EH-14 (SR 620°C/1hr.)	420	520	28	70	50
SFA 5.17 EH-10K (As-welded)	470	550	26	70	50
SFA 5.17 EH-10K (SR 620°C/1hr.)	440	530	28	80	60
SFA 5.23 EA-2 (As-welded)	530	620	26	40	-
SFA 5.23 EA-2 (SR 620°C/1hr.)	510	580	27	50	-

Manufactured By :

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Major Constituents:

SiO₂ + TiO₂	CaO + MgO	Al₂O₃ + MnO	CAF₂
14%	38%	26%	22%

BASICITY INDEX	: ~1.6
GRAIN SIZE	: 0.35-1.20 mm
PACKAGING	: 25 kg. Bag
RE-DRYING CONDITIONS	: 300-350°C for 2 hours before use.