

TH-50N-4



C	Mn	Si	Cr	Ni	Mo
0.15	0.25	0.65	11.00	3.5	0.75

Typical hardness of weld metal:

Testing Condition	Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
Interpass temp. 150 (As Welded)	510	50	66

Welding position:



Sizes and recommended current range (AC or DC +):

Diameter (mm)	3.2	4.0	4.8
Length (mm)	350	350	350
Amps	80-130	120-180	160-220

Information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability for any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. This data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.

COVERED ELECTRODES

* The
incl
no c

No. 6, Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan.



TEL: 886-6-2663721 / FAX: 886-6-2664301
E-mail: twtrad@twweld.com
http://www.tientai.com