

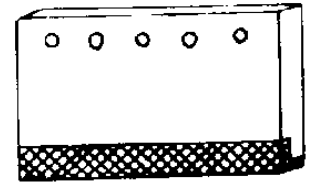
# TH-80

## Characteristics and Applications:

TH-80 deposits a self-hardening martensite structure. It is suitable for pump impeller, cutter blades, agitator propeller, sugar cane hammers and bulldozing parts.

## Notes on usage:

1. Dry the electrodes at 300-350 for 60 minutes before using.
2. Clean up the contaminations on the steel.
3. Take the back-step method to prevent blowhole at the arc starting.
4. Preheat the plates and keep the inter-pass temperature above 200 to prevent cracking.
5. Use low hydrogen electrode for buffer layer on difficult-to-weld steels.



Bulldozing Plate

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

C	Mn	Si	Mo	Cr
0.50	0.70	2.0	0.003	8.0

## Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)		Rockwell's Hardness (HRC)		Shore's Hardness (HS)	
Interpass temp. 150		660		58		79	
Cont. Build Up		620		56		76	
As Welded	Temp( )	200	300	400	500	600	700
	Hardness(HV)	510	470	420	410	200	90

## Welding position:



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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	450	450
Amps	80-130	120-180	160-220

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