

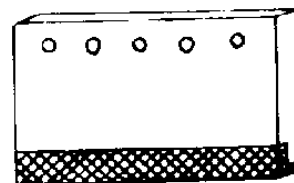
TH-80

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

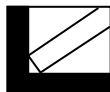
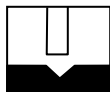
Typical chemical composition of weld metal (wt%):

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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