

## Characteristics and Applications:

TH-80R deposits a self-hardening martensite structure. It features high strength and good slag removability. It is suitable for pump impeller, cutter blades, agitator propeller, such as hammers.

## Notes on usage:

1. Dry the electrodes at 80-120 °C 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. Pre-heat the plates and keep the inter-pass temperature above 200 °C to prevent cracking.
5. Use low hydrogen electrode for buffer layer on difficult-to-weld steels.

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

C	Mn	Si	Cr	Mo
0.4	0.40	0.45	4.5	0.004

COVER

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