

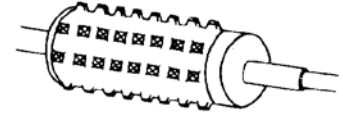
TH-90

Characteristics and Applications:

TH-90 deposits a self-hardening martensite structure which contains carbide-forming elements such as Cr, B. Machining is difficult in as welded condition. The weld metal provides high hardness and good abrasion resistance accompanied with medium impact. It is suitable for earthwork, sand pump and bucket.

Notes on usage:

1. Dry the electrodes at 300-350



0.60	1.20	0.9	6.5	1.2~2.0

Testing Condition		Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
As	Interpass temp. 100	740	60	85
Welded	Cont. Build Up	700	60	82

Welding position:



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

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	450	450
Amps	80-120	120-170	160-210

RED ELECTRODES

COVE

TienTai Electrode Co., Ltd. expressly disclaims any liability

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd.