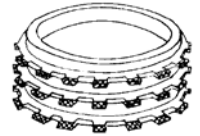


# TH-950B

## Characteristics and Applications:

TH-950B deposits the weld metal of high Cr martensite structure containing carbides. The weld metal has high hardness, resistance to earth abrasion. Less resistance to abrasion accompanied by heavy impact. It is suitable for various rollers and crusher mantles.



Mill roller wheel

## Notes on usage:

1. Dry the electrodes at 300-350 for 30-60 minutes before using.
2. Clean up the contaminations on the base metal to avoid porosity and crack.
3. Use back-step method to prevent arc starting from blowholes and stay for 3-5 seconds before every end-up.
4. Maintain short arc length. Moving range should be controlled within 2.5 times of the wire's dia when you are welding with weave method.
5. Preheat over 400 in order to relieve crack.

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

C	Mn	Si	Cr	Mo
5.6	3.2	1.45	28.0	0.58

## Typical hardness of weld metal:

Testing Condition		Vicker's Hardness (HV)	Rockwell's Hardness (HRC)	Shore's Hardness (HS)
As Welded	Interpass temp. 150	740	62	85
	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	350	450
Amps	90-140	140-190	190-240

COVER

d. 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

and procedures may produce different results. This data is obtained when welded and tested in accordance with AWS specification. Other conditions may affect the results. The information is provided for reference only. The information is not intended to be used as a substitute for the manufacturer's recommendations. The information is not intended to be used as a substitute for the manufacturer's recommendations. The information is not intended to be used as a substitute for the manufacturer's recommendations.

.. Rende Dist., Tainan City, 717, Taiwan  
/FAX: 886-6-2664301

www.tenta.com  
/www.tenta.com



No.6, Kaifa 4th Rd  
TEL: 886-6-2663721  
E-mail: tentac@tenta.com.tw  
1705

RED ELECTRODES