

# TWH-34-O

## Characteristics and Applications:

TWH-34-O is a self-shielded flux-cored wire for building up or hardfacing on worn workpieces. The hardness of the deposited metal is about HRC 34 which can be machined by carbide tools. It is designed for hardfacing or build-up or repair of tractor roll, shaft, mine car wheel, gear and workpieces which medium hardness is required.

## Notes on usage:

1. The DC(+) polarity is recommended.
2. The pre-heat and inter-pass temperatures should be between 150-250 for massive workpieces.
3. Dry the workpiece in advance to prevent from porosity caused by remnant moisture.

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

C	Mn	Si	Cr
0.16	2.0	0.5	1.2

## Range of weld metal hardness (on mild steel):

Layer	1st layer	2nd layer	3rd layer
Hardness (HRC)	23-29	27-32	30-34

## Suggested welding parameter (DC<+>):

Parameters	Diameter (mm)	2.4	2.8
	Volt		25-32
Amps		250-400	300-450
Stick out (mm)		50-60	50-60

LUX CORED WIRES

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No data is to be construed as recommendation for any welding condition or technique.